Grizzly Industrial, Inc.®

15" PLANER

MODEL G0550/G0551

INSTRUCTION MANUAL

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ONLINE MANUAL DISCLAIMER

THE INFORMATION IN THIS MANUAL REPRESENTS THE CONFIGURATION OF THE MACHINE AS IT IS CURRENTLY BEING SHIPPED. THE MACHINE CONFIGURATION CAN CHANGE AS PRODUCT IMPROVEMENTS ARE INCORPORATED. IF YOU OWN AN EARLIER VERSION OF THE MACHINE, THIS MANUAL MAY NOT EXACTLY DEPICT YOUR MACHINE . CONTACT CUSTOMER SERVICE IF YOU HAVE ANY QUESTIONS ABOUT DIFFERENCES. PREVIOUS VERSIONS ARE NOT AVAILABLE ONLINE.

WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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SECTION 1: SAFETY

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER — **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING — **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION — **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE — **This symbol is used to alert the user to useful information about proper operation of the equipment.**

⚠WARNING

Safety Instructions For Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.

2. **REMOVE ADJUSTING KEYS AND WRENCHES**. Form a habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.

3. **KEEP WORK AREA CLEAN**. Cluttered areas and benches invite accidents.

4. **NEVER USE IN DANGEROUS ENVIRONMENT**. DO NOT use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.

5. **KEEP CHILDREN AND VISITORS AWAY**. All children and visitors should be kept at a safe distance from work area.

6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.

7. **NEVER FORCE TOOL**. It will do the job better and safer at the rate for which it was designed.

8. **USE RIGHT TOOL.** DO NOT force tool or attachment to do a job for which it was not designed.

⚠WARNING
Safety Instructions For Power Tools

9. **USE PROPER EXTENSION CORD**. Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

	LENGTH		
AMP RATING	25ft	50ft	100ft
0-6	16	16	16
7-10	16	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

10. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.

13. **DO NOT OVER-REACH.** Keep proper footing and balance at all times.

14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

17. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

18. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** DO NOT leave tool until it comes to a complete stop.

19. **NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

20. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to machine operation are approved, correct, safe, and clearly understood.

21. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES** performing the intended operation, stop using the machine! Then contact our service department or ask a qualified expert how the operation should be performed.

⚠WARNING

Additional Safety Instructions For Planers

1. **READ THIS ENTIRE MANUAL BEFORE TURNING THE PLANER *ON*.**
2. **ENSURE THAT THE MACHINE IS ON FLAT, STABLE GROUND BEFORE USE.** Any "wobbles" must be corrected by shimming or blocking before operation.
3. **NEVER PLANE MATERIAL OTHER THAN WOOD STOCK WITH THIS MACHINE.**
4. **NEVER POSITION FINGERS OR THUMBS NEAR THE INFEED ROLLER.**
5. **ENSURE THAT THE PLANER IS PROPERLY ADJUSTED AND THAT THERE ARE NO LOOSE PARTS BEFORE OPERATING.**
6. **PLANE IN THE SAME DIRECTION AS THE GRAIN OF THE WOOD STOCK.**
7. **ALWAYS STAND TO THE SIDE OF THE PLANER WHILE FEEDING THE WORKPIECE.**
8. **DO NOT LOOK INSIDE THE PLANER DURING OPERATION!**
9. **ALWAYS PROVIDE ADEQUATE INFEED AND OUTFEED SPACE WHEN OPERATING THE PLANER.** Always support long pieces of stock on both sides of the planer.
10. **DO NOT REMOVE MORE THAN ⅛" FROM THE SURFACE OF THE WOOD STOCK IN A SINGLE PASS.**
11. **INSPECT YOUR STOCK BEFORE PLANING.** Never plane stock with nails, staples or other foreign objects which may be embedded in the surface. Always properly prepare workpieces before running them through the planer. Do not plane lumber with loose knots or knots that may become loose during planing.
12. **DO NOT ATTEMPT TO REMOVE JAMS UNTIL POWER IS DISCONNECTED** and all moving parts have come to a complete stop.
13. **DO NOT PLANE WORKPIECES LESS THAN 12" LONG AND ¼" THICK.**
14. **DO NOT OPERATE PLANER WITH DULL OR DAMAGED KNIVES.**
15. **ALWAYS UNPLUG THE PLANER WHENEVER MAKING ANY ADJUSTMENTS** or changing knives.
16. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE PLANER!** Then contact our service department or ask a qualified expert how the operation should be performed.

⚠WARNING

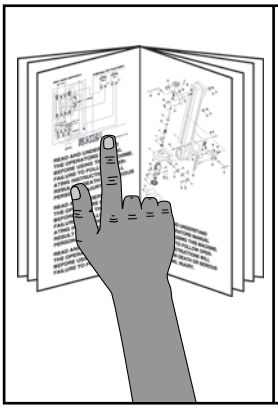
Like all machines there is danger associated with the Model G0550/G0551. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

SECTION 2: INTRODUCTION

Commentary



⚠WARNING

Lack of familiarity with this manual could cause serious personal injury. Become familiar with the contents of this manual, including all the safety warnings.

We are proud to offer the Model G0550/G0551 15" Planer. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0550/G0551. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible. If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

Most importantly, we stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com

The specifications, drawings, and photographs illustrated in this manual represent the Model G0550/G0551 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at www.grizzly.com. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

SECTION 3: CIRCUIT REQUIREMENTS

Amperage Draw

The Model G0550/G0551 motor is wired to operate at 220V only. The planer motors draw the following amperage:

Amperage Draw
G0550 2 HP.....12 Amps
G0551 3 HP.....18 Amps

Circuit Breaker

Use the following guidelines when choosing a circuit breaker (circuit breakers rated any higher are not adequate to protect the circuit):

Circuit Breaker
G0550 .....15 Amp, 2 Pole
G0551 .....20 Amp, 2 Pole

Plug-Type

We recommend using a NEMA-style 6-15 plug and outlet with the G0550 as shown in **Figure 1a** and an L6-20 plug and outlet for the G0551 as shown in **Figure 1b.** You may also "hard-wire" the planer directly to your panel, provided you place a disconnect near the machine. Check the electrical codes in your area for specifics on wiring requirements.

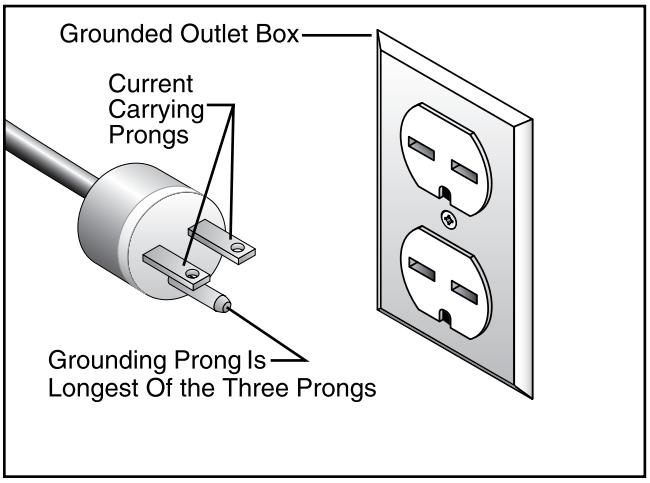


Figure 1a. NEMA 6-15 plug and receptacle.

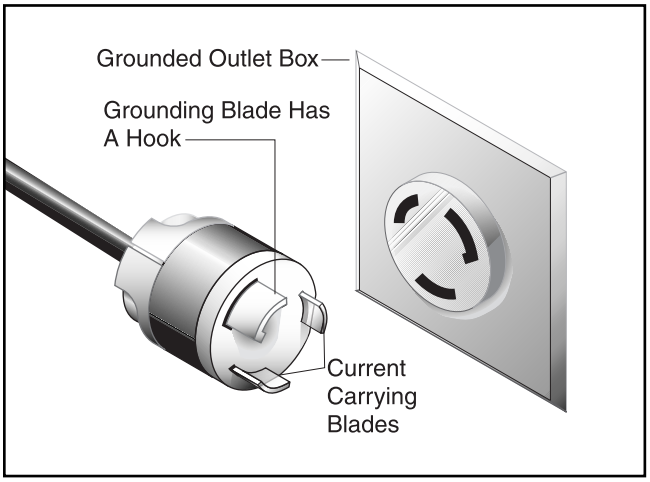


Figure 1b. NEMA L6-20 plug and receptacle.

Circuit Capacity

Always check to see if the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.

If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified electrician.

Grounding

⚠WARNING

Electrocution or a fire can result if the machine is not grounded correctly. Make sure all electrical circuits are grounded. DO NOT use the machine if it is not grounded.

In the event of an electrical short, grounding reduces the risk of electric shock by providing a path of least resistance to disperse electric current. This tool is equipped with a power cord that has an equipment-grounding prong. The outlet must be properly installed and grounded in accordance with all local codes and ordinances.

Extension Cords

220V Operation
We do not recommend the use of extension cords on 220V equipment. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

If you find it absolutely necessary to use an extension cord at 220V with your Grizzly Planer:

- Make sure the cord is rated for Standard Service (grade S) or better.
- The extension cord must also contain a ground wire and plug prong.
- Use at least a 16 gauge cord if the cord is 50 feet long or less.
- Use at least a 14 gauge cord if the cord is between 51-100 feet.

SECTION 4: MACHINE FEATURES

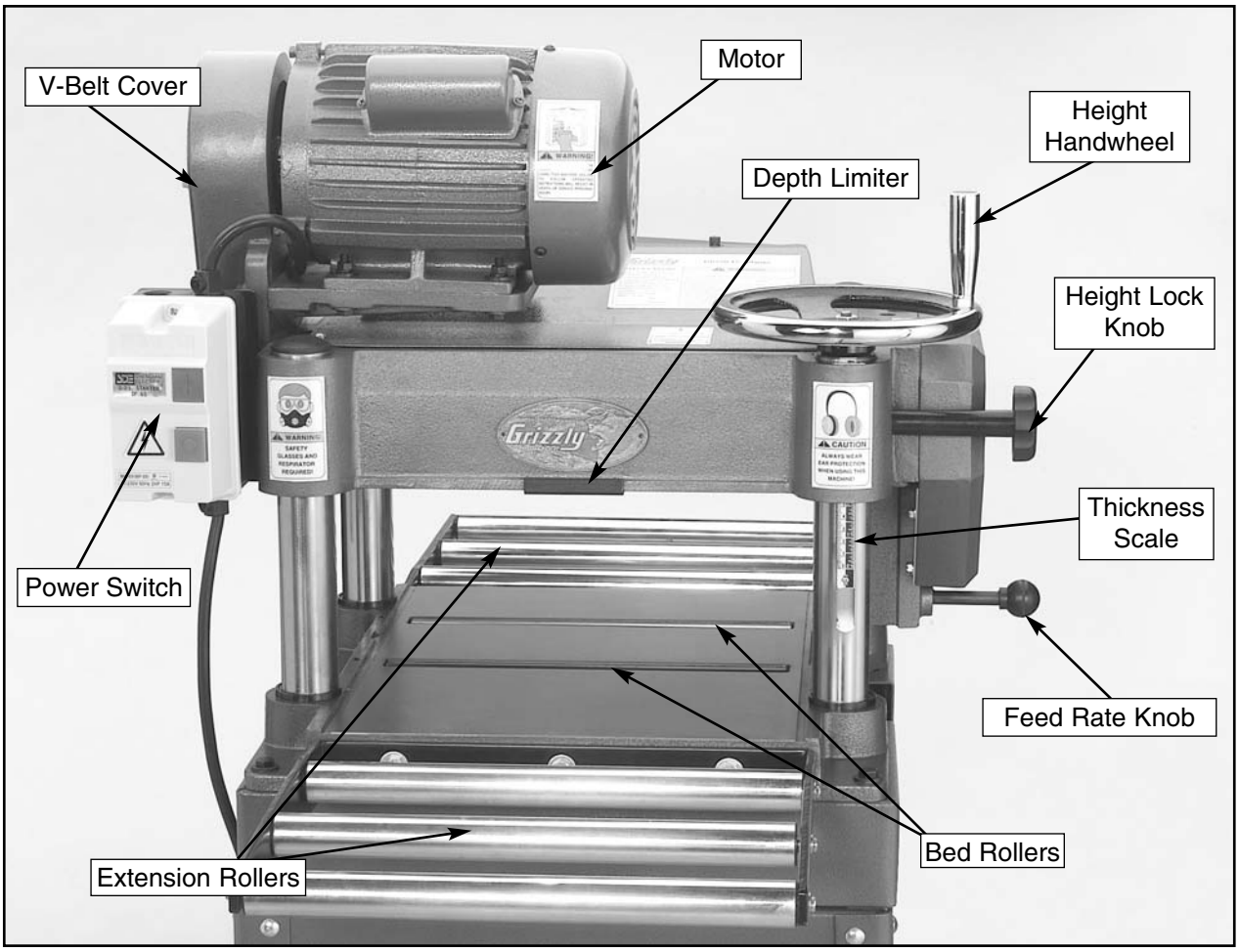


Figure 2. Machine features.

Common Terms & Definitions

Work Table: The wood moves through the planer on the work table.

Infeed and Outfeed Rollers: Powered rollers that move the wood through the planer.

Cutterhead: The cutterhead holds the knives and spins at 5000 rpm. When wood passes under the cutterhead, material is removed.

Chip Breaker: Spring loaded fingers or bar that presses down on the wood in front of the cutterhead. The chip breaker prevents excessive chipping caused by the knives.

Snipe: A gouge at the end of the board.

Pressure Bar: Rides on the planed surface behind the cutterhead. Prevents vibration, chattering and snipe.

Bed Rollers: Located in the work table, the bed rollers help wood move through the planer.

Dust Hood: Funnels wood dust and chips into the dust collection system.

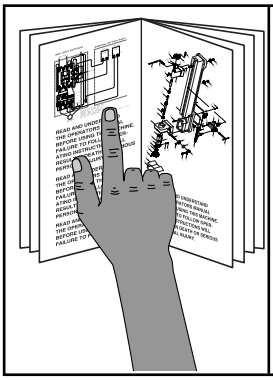
Gibs: Metal strips that hold the planer knives in place.

Gib Bolts: Secures the gib to the knife to keep it in place.

SECTION 5: SET UP

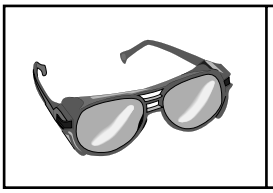
About This Section

The purpose of this section is to guide you through the required steps to get your machine out of its packaging and into operating condition.



⚠WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



⚠WARNING

Wear safety glasses during the entire set up process!

Unpacking

The Model G0550/G0551 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the parts.

Parts Inventory

The Model G0550 comes with an open stand that requires assembly, and the Model G0551 comes assembled on a closed cabinet stand.

The following is an inventory of the parts for your new Model G0550/G0551 Planer.

Figure 3. G0550 planer unit.

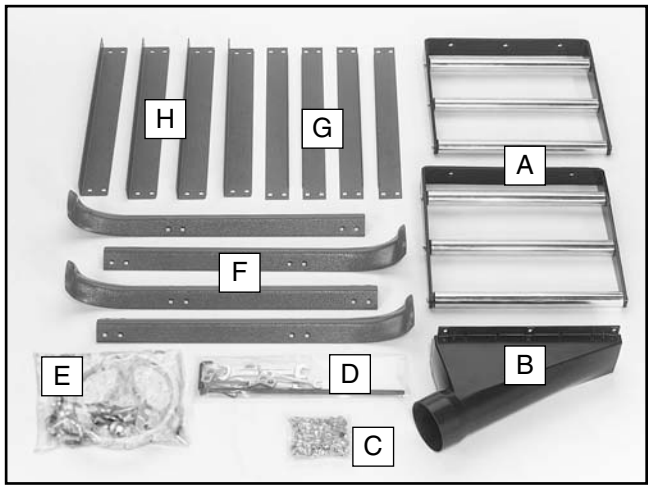


Figure 4. G0550 loose parts.

G0550 Loose Parts

DESCRIPTION	QTY
A. Extension Rollers	2
B. Dust Port	1
C. Stand Hardware Bag	1
— Carriage Bolts 5/16"-18 x 1/2"	32
— Hex Nuts 5/16"-18	36
— Flat Washers 5/16"	36
— Lock Washer 5/16"	4
— Hex Bolts 5/16"-18 x 1"	4
D. Tool Bag	1
— Handwheel Handle	1
— Combo Wrench 8/10mm	1
— Combo Wrench 12/14mm	1
— Allen Wrench 6mm	1
— Allen Wrench 5mm	1
— Allen Wrench 4mm	1
— Allen Wrench 3mm	1
— Knife Jig Shaft	1
— Knife Jig Feet	2
— E-Clips 9mm	4
E. Handwheel Bag	1
— Handwheel	1
— High/Low Label	1
— Flat Washer 10mm	1
— Hex Nut M10-1.5	1
Extension Roller Hardware Bag	1
— Hex Bolt M8-1.25 x 20	6
— Flat Washer 8mm	6
— Setscrew M8-1.25 x 12	6
Dust Port Hardware Bag	1
— Phillips Head Screw M6-1.0 x 12	6
F. Legs	4
G. Lower Braces	4
H. Predrilled Upper Braces	4

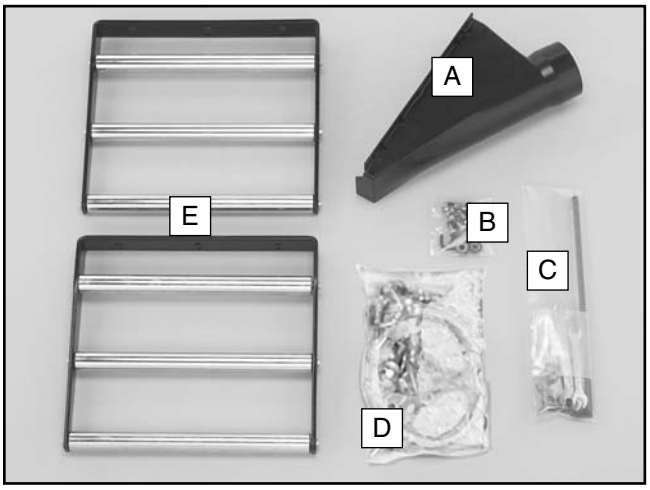
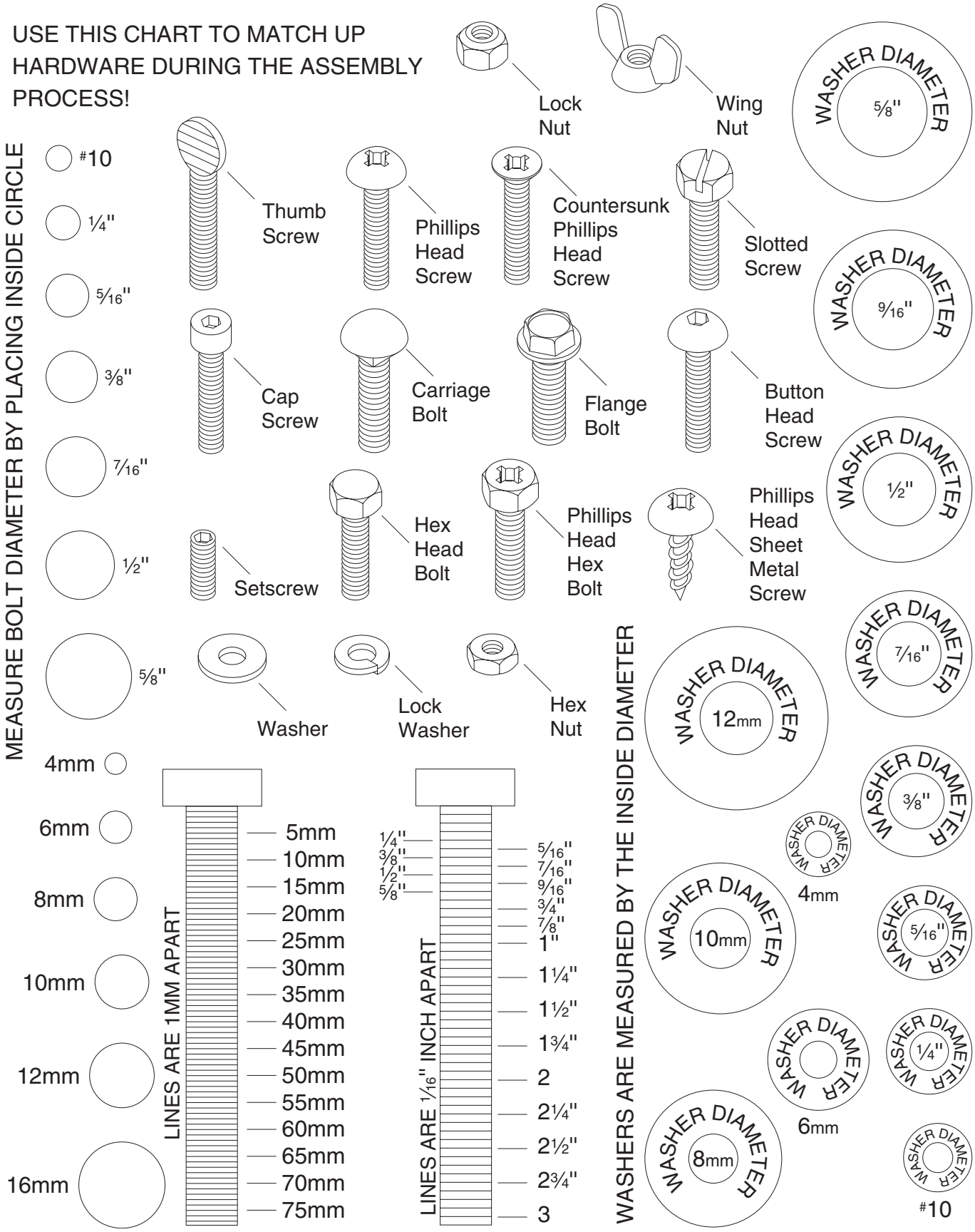


Figure 5. G0551 loose parts.

G0551 Loose Parts

DESCRIPTION	QTY
A. Dust Port	1
B. Extension Roller Hardware Bag	1
— Hex Bolts M8-1.25 x 20	6
— Flat Washers 8mm	6
— Setscrews M8-1.25 x 12	6
C. Tool Bag	2
— Handwheel Handle	1
— Combo Wrench 8/10mm	1
— Combo Wrench 12/14mm	1
— Allen Wrench 6mm	1
— Allen Wrench 5mm	1
— Allen Wrench 4mm	1
— Allen Wrench 3mm	1
— Knife Jig Shaft	1
— Knife Jig Feet	2
— E-Clips 9mm	4
D. Handwheel Bag	1
— Handwheel	1
— High/Low Label	1
— Flat Washer 10mm	1
— Hex Nut M10-1.5	1
Foot Hardware Bag	1
— Foot	4
— Hex Nut M8-1.25	4
Dust Port Hardware Bag	1
— Phillips Head Screw M6-1.0 x 12	6
E. Extension Rollers	2

Hardware Recognition Chart



Site Considerations

Floor Load
The Model G0550 weighs 410 lbs and has a 25" x 25" footprint. The Model G0551 weighs 450 lbs and has a 21" x 21" footprint. Most commercial floors are suitable for the machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Working Clearances
Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for the machine. See **Figure 6** for the overall dimensions of the Model G0550/G0551.

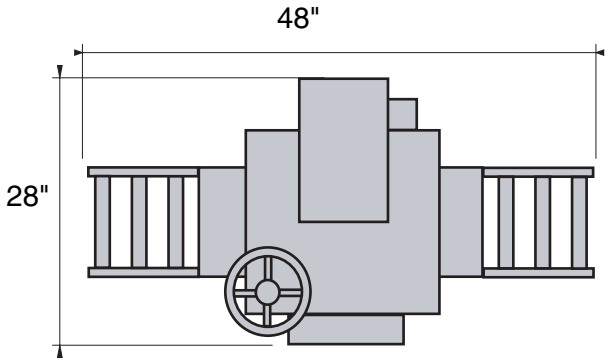
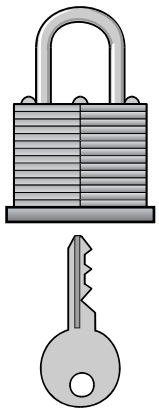


Figure 6. Overall machine dimensions.



⚠WARNING

Unsupervised children and visitors inside your shop could receive serious personal injury. Ensure child and visitor safety by keeping all entrances to the shop locked at all times. DO NOT allow unsupervised children or visitors in the shop at any time.

Clean Up

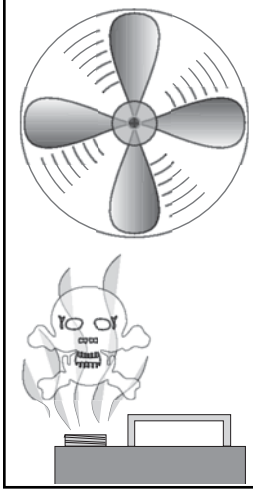
The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact.

⚠WARNING

Gasoline and petroleum products have low flash points and could explode if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.

⚠WARNING

Smoking near solvents could ignite an explosion or fire and cause serious injury. DO NOT smoke while using solvents.



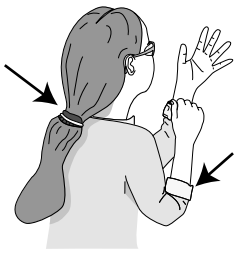
⚠CAUTION

Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.

Beginning Assembly

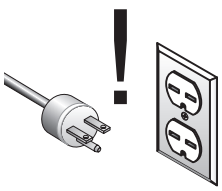
This section covers the basic assembly and adjustment instructions needed to begin operation. Complete the assembly in the order provided in this manual and then read the remaining portion of the manual before attempting any type of operation.

Your safety is important! Please follow the warnings below during this entire section:



⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.



⚠WARNING

Disconnect power to the machine during the entire assembly process. Failure to do this may result in serious personal injury.

⚠CAUTION

Sharp edges on metal parts may cause personal injury. Examine the edges of all metal parts before handling.

G0550 Open Stand

Components and Hardware Needed: Qty

Legs 4
Lower Braces 4
Predrilled Upper Braces 4
Carriage Bolts 5/16"-18 x 1/2" 32
Hex Nuts 5/16"-18.....32
Flat Washers 5/16" 32

Tools Needed:

12/14mm Combo Wrench 1

Note—*The following steps are for the G0550 only.*

To assemble the open stand:

1. Connect the lower and upper braces to the legs of the stand with the carriage bolts, hex nuts and flat washers. See **Figure 7**.

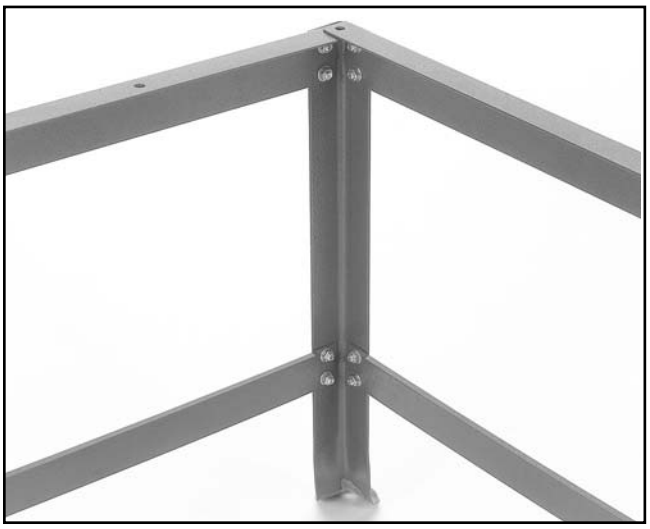


Figure 7. Upper and lower braces connected to leg.

2. Connect the remaining legs and braces together. Finger tighten the carriage bolts that connect the legs to the upper braces. The finished stand assembly should look like **Figure 8**.

Figure 8. Assembled stand.

Mounting Planer (G0550)

Components and Hardware Needed: ....Qty
Planer Unit 1
Assembled Stand 1
Hex Bolt 5/16"-18 x 1" 4
Hex Nut 5/16"-18 4
Flat Washer 5/16" 4
Lock Washer 5/16".....4

Tools Needed:
12/14mm Combo Wrench 2
Strong Persons 4

To mount the planer:

1. **Do not connect the planer to a power source!**

2. Place two 2x4 boards under the cutterhead of the planer unit. Note—*Make sure that the boards are long enough so that they protrude from the planer at least 16" on each side.*

⚠CAUTION

The planer unit represents a heavy load at 400 pounds. Seek assistance before mounting the planer.

3. Have one person on each end of each 2x4 and carefully lift the planer unit onto the stand.

4. Line up the holes in the corners of the stand with the holes under the planer unit.

5. Attach the planer to the stand with the four hex bolts, 4 hex nuts, and 8 washers.

6. Tighten down the carriage bolts on the upper half of the stand that were finger tightened in the previous section.

Dust Port

Components and Hardware Needed: ....Qty
Dust Port 1
Phillips Head Screw M6-1 x 12.....6

Tools Needed:
Phillips Head Screwdriver 1

It is important to install a dust collection system to the dust port.

To install the dust port:

1. **Do not connect the planer to a power source!**

2. Place the dust port above the outfeed table. See **Figure 9**.

3. Secure the dust port with the Phillips head screws provided.

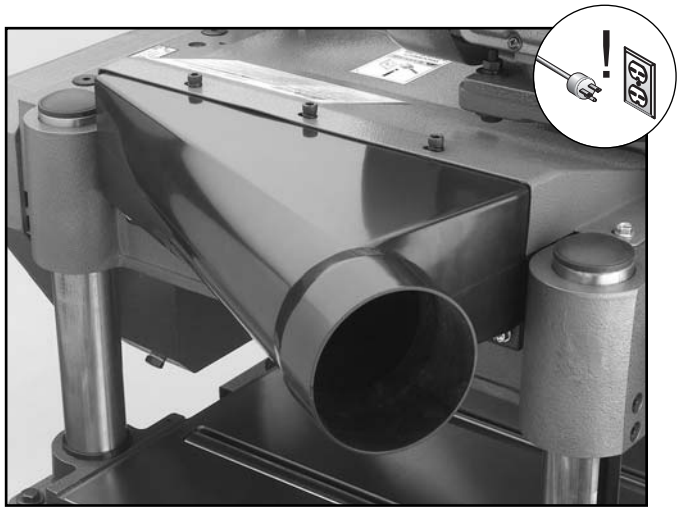


Figure 9. Dust port installed.

Handwheel

Components and Hardware Needed: ....Qty
Handwheel 1
Handwheel Handle 1
Hex Nut M10-1.5.....1
Flat Washer 10mm 1
High/Low Label 1

Tools Needed:
12/14mm Combo Wrench 1

The handwheel is used to raise and lower the planer cutterhead.

To install the handwheel:

1. **Do not connect the planer to a power source!**

2. Place the handwheel over the keyed shaft shown in **Figure 10**. Make sure the keyway in the handwheel lines up with the key in the shaft.

3. Secure the handwheel with the hex nut and washer.

4. Attach the handle to the outer edge of the handwheel.

5. Install the High/Low label around the hex nut.

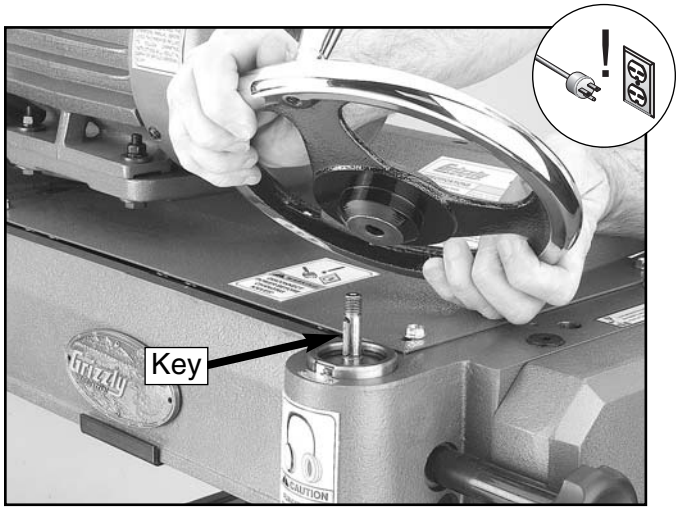


Figure 10. Installing handwheel.

Extension Rollers

Components and Hardware Needed: **Qty**
Extension Rollers 2

Tools Needed:
12/14mm Combo Wrench 1
Allen Wrench 4mm 1

To install the extension rollers:

1. **Do not connect the planer to a power source!**

2. Remove the three hex bolts and washers from below the outfeed and infeed tables.

3. Position the extension rollers over the holes.

4. Finger-tighten the hardware removed in **step 2** to secure the extension rails to the planer as shown in **Figure 11**.

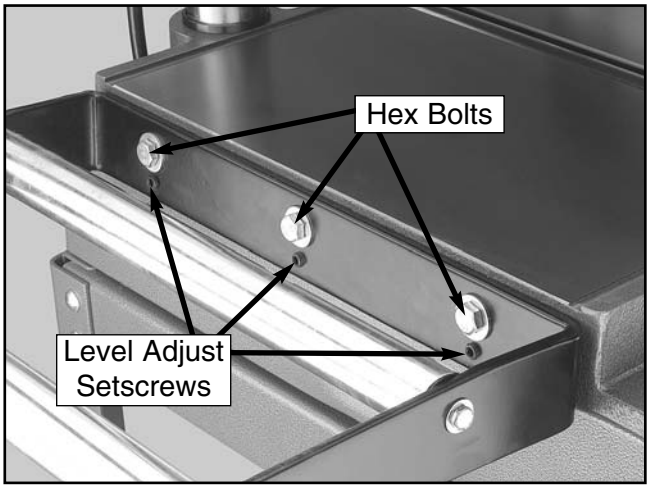


Figure 11. Extension rollers.

5. Loosen the bed roller setscrews and turn the eccentric shaft so the table rollers are beneath the table surface. See **Figure 12.**

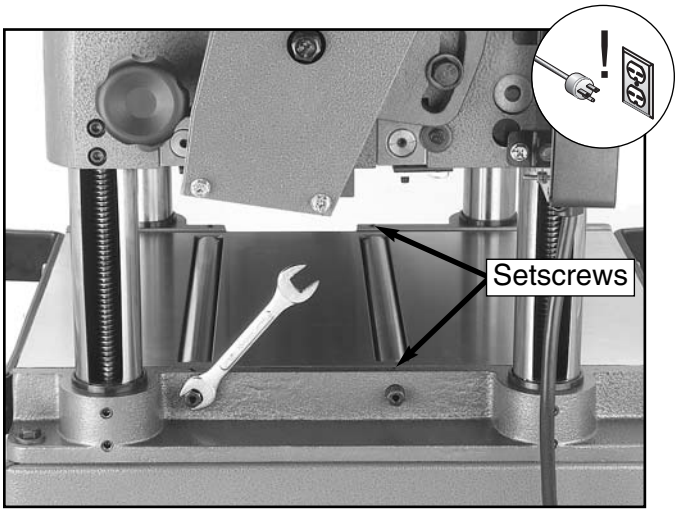


Figure 12. Bed roller.

6. Use a straightedge to check table-to-extension roller alignment as shown in **Figure 13**.

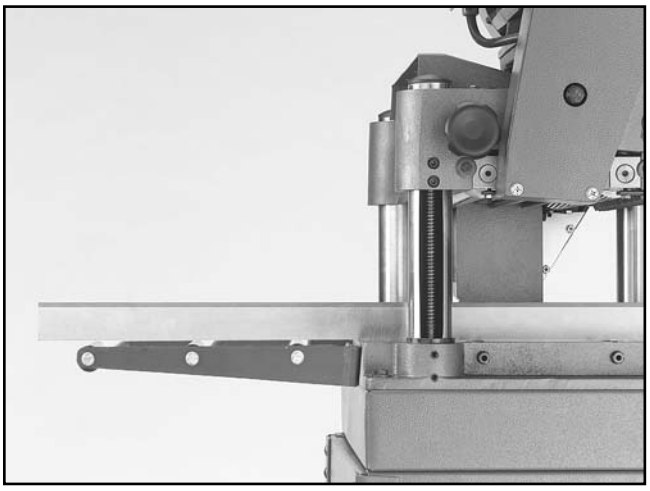


Figure 13. Checking extension roller alignment..

7. Adjust the leveling setscrews shown in **Figure 11** if the table and extension rollers are not flush.

Knife Setting Jig

Components and Hardware Needed: Qty
Knife Jig Shaft 1
Knife Jig Feet.....2
E-Clips 9mm 4

To assemble the knife setting jig:

1. Snap one of the E-clips over the notch on one end of the knife setting shaft.

2. Slide the cast aluminum knife setting jig feet onto the rod.

3. Snap the other E-clip onto the notch at the other end of the knife setting jig shaft.

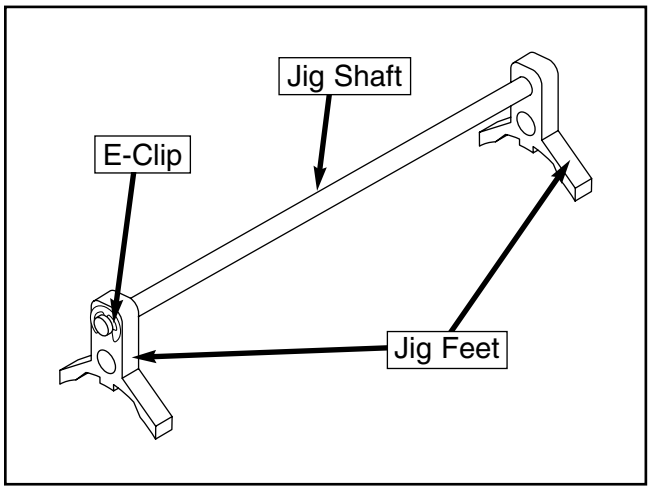


Figure 14. Knife setting jig.

Start Up

⚠WARNING

Loose hair and clothing could get caught in machinery causing serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.

⚠WARNING

Projectiles thrown from the machine could cause serious eye injury. Wear safety glasses during assembly and operation.

Starting the machine:

1. Read the entire instruction manual.
2. Make sure all tools and foreign objects have been removed from the machine.
3. Review *Section 3: Circuit Requirements* (**Page 6**).
4. Keep your finger on the *STOP* button at all times during the test run.

Starting the machine:
Press the *START* button to turn the machine *ON*. The machine should run smoothly with little or no vibration.

Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory and no further setup is required to operate your machine.

However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure the best possible results from your new machine.

Step-by-step instructions on verifying these adjustments can be found in *Section 8: Service Adjustments*.

Factory adjustments that should be verified:

1. Table Adjustment (**page 29**)
2. Thickness Scale (**page 30**)
3. Knife Setting (**page 32**)
4. Chip Breaker (**page 33**)
5. Feed Roller Height (**page 34**)
6. Bed Roller (**page 35**)
7. Feed Roller Pressure (**page 36**)
8. Chip Deflector (**page 37**)

SECTION 6: OPERATIONS

General

Your safety is important! Please follow the warnings below during this entire section:

⚠WARNING

Damage to your eyes, lungs, and ears could result from failure to wear safety glasses, a respirator, and hearing protection while using this machine.

⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.

Cutterhead Locks

There is a cutterhead lock knob on each side of the planer that must be loosened before adjusting the height. Once the height has been set, tighten the lock knobs. See **Figure 15**.

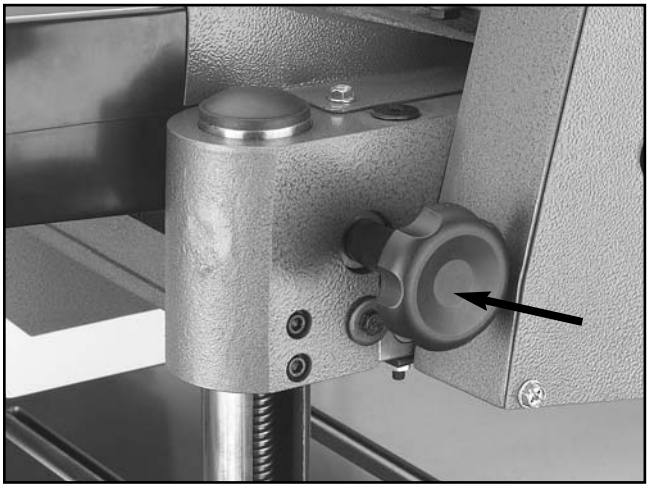


Figure 15. Cutterhead lock knob.

NOTICE

Lock down the cutterhead with the cutterhead lock knobs before planing or snipe will occur.

Power Feed

The power feed can be set for two feed rates—16 FPM and 20 FPM. While the planer is running the feed rate can be changed by pulling the feed control knob (**Figure 16**). Press the knob in towards the machine for 20 FPM and pull the knob out for 16 FPM. When the control knob is in the center position, the power feed is in neutral.

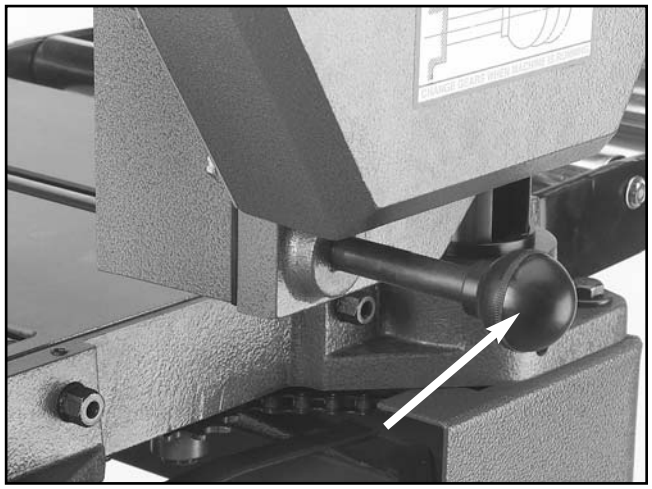


Figure 16. Power feed knob.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

Handwheel

Turn the handwheel to raise or lower the cutterhead, according to the workpiece thickness.

Each complete revolution of the handwheel moves the table by 5/32" (4mm).

Make sure the height scale is properly adjusted before making a cut. It is always a good idea to run a test piece through the planer and compare the thickness of the workpiece to the scale reading.

Depth Limiter

The depth limiter, shown in **Figure 17**, controls the maximum depth of cut to 1/8". To avoid mechanical damage to the planer and workpiece do not remove the depth limiter.

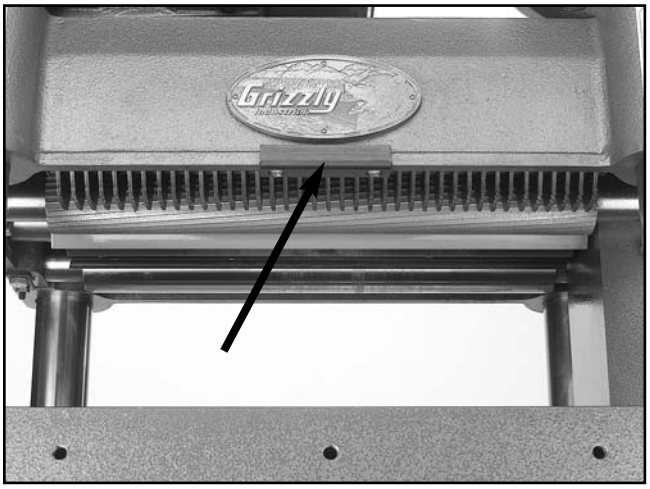


Figure 17. Depth limiter.

NOTICE

To avoid mechanical damage to the planer, do not remove the depth limiter.

Anti-Kickback

The anti-kickback fingers hang from a rod suspended across the front of the cutterhead casting. Check the fingers to ensure that they swing freely and easily. See **Figure 18**.

⚠WARNING

DO NOT apply oil or other lubricants to the anti-kickback fingers. Oil or grease will attract dust and restrict movement of the fingers, which could result in damage to your workpiece, the planer, or possibly serious injury to the operator.

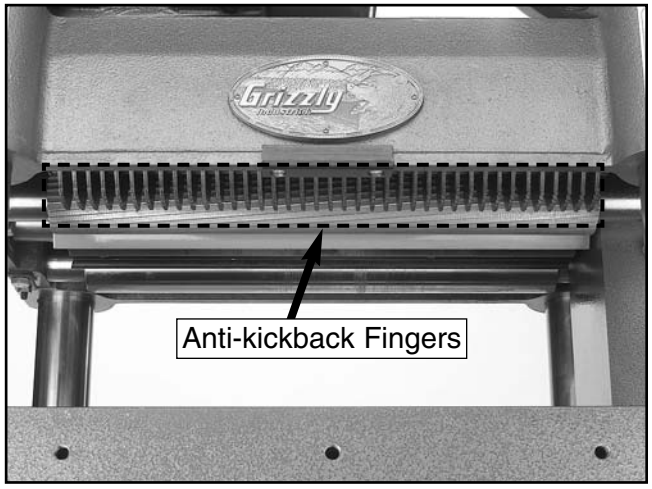


Figure 18. Anti-kickback fingers.

Wood Species

The species of wood, as well as its condition, have a dramatic effect on planing ability. The harder the wood (as illustrated by its shear strength), the more difficult it will be to plane. A brief listing of common hard and soft woods in relation to their shear strengths and planing difficulty is listed below.

Increasing Difficulty ↑

Type	Shear (PSI)
Black Locust	2,480
Sugar Maple	2,330
Pecan Hickory	2,080
White Oak	2,000
White Ash	1,950
Black Cherry	1,700
American Elm	1,510
Black Walnut	1,370
Red Alder	1,080
Basswood	980
Cottonwood	930

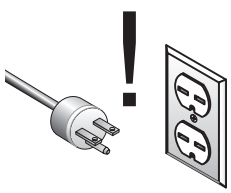
Increasing Difficulty ↑

Type	Shear (PSI)
Western Larch	1,410
Tamarack	1,280
Douglas Fir	1,160
Alaska Cedar	1,130
Sitka Spruce	1,150
Sugar Pine	1,050
Cypress	1,000
Redwood (OG)	940
Red Cedar	860
White Pine	850
Balsam Fir	710

SECTION 7: MAINTENANCE

Maintenance Safety

Your safety is important! Please follow the warnings below during this entire section:



⚠WARNING

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.

⚠WARNING

Projectiles from the machine could cause serious eye injury. Wear safety glasses at all times.

General

Regular periodic maintenance on the Model G0550/G0551 will ensure optimum performance. Make a habit of inspecting the machine each time you use it.

Before each use, look for the following conditions:

1. Loose mounting bolts.
2. Worn switch.
3. Worn or damaged cords and plugs.
4. Damaged V-belt.
5. Any other condition that could hamper the safe operation of this machine.

Table

The table and other non-painted surfaces on your machine should be protected against rust and pitting. Wiping the table clean after every use ensures that moisture from wood dust does not remain on bare metal surfaces.

Tables can be kept rust-free with regular applications of products like SLIPIT® or Boeshield® T-9. For long term storage you may want to consider products like Kleen Bore's Rust Guardit™.

V-Belts

To ensure optimum power transmission from the motor to the blade, the V-belts must be in good condition (free from cracks, fraying and wear). Check the V-belts at least every 3 months; more often if the planer is used daily.

Make sure that the motor pulley and cutterhead pulley are aligned and the V-Belts are properly tensioned.

To align the V-Belt:

1. **Disconnect the machine from the power source!**

2. Remove the V-Belt cover.

3. Loosen the bolts that mount the motor to the motor mount bracket.

4. Adjust the position of the motor until the pulleys are in line, and check the alignment with a straightedge as shown in **Figure 19**.

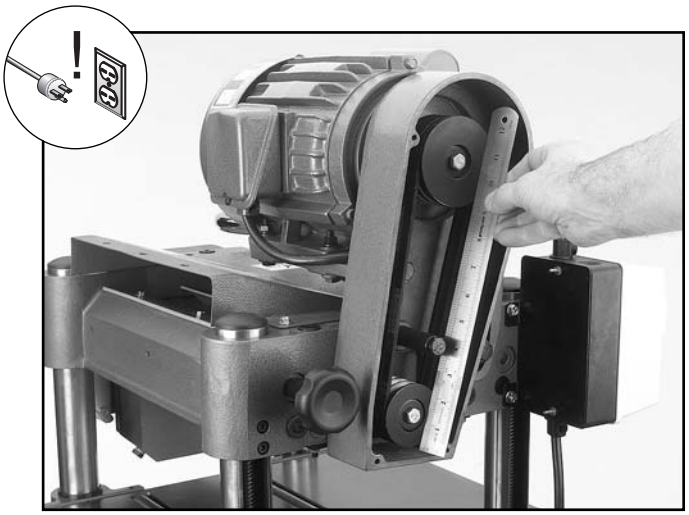


Figure 19. Checking pulley alignment.

Squeeze the V-Belts at their midpoints with moderate finger pressure. You should be able to deflect each V-Belt about 3/4". Belts will rarely be too tight, but will sometimes be too loose.

To tension the V-Belt:

1. **Disconnect the machine from the power source!**

2. Insert a wooden lever between the motor mount and the top of the planer as shown in **Figure 20**.

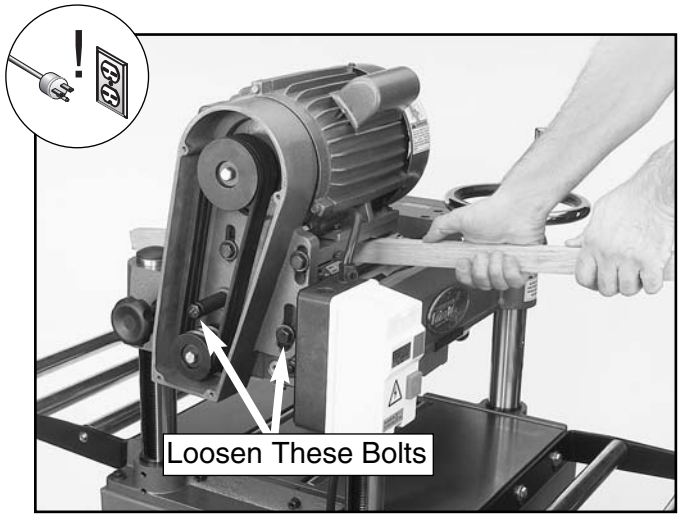


Figure 20. Tensioning Belt.

3. Loosen the two bolts that hold the motor pulley assembly to the planer (**Figure 19**).

4. Lift the motor assembly with the wooden lever until the belt is tensioned correctly.

5. Hold the motor in place and secure the bolts loosened in **step 3**.

6. Squeeze the belts to check the tension and repeat **steps 2-5** if necessary.

Gearbox

The gearbox is located just behind the handwheel on the right side of the planer. The gearbox transfers power from the belt-driven cutterhead to the power feed rollers. The two-speed transmission is controlled by a push/pull lever on the right side of the planer. When engaged, the power feed rollers will move lumber through the planer at either 16 or 20 feet-per-minute. The center lever position is neutral.

To inspect the gearbox:

1. Loosen the socket head cap screw on the gearbox cover, and gently pull the cover off the roll pins that hold it in place.

2. Check the bolts that hold the sprockets in place. Inspect the drive chains to ensure that the retaining clips are in place. Replace the clips if necessary. See **Figure 21**.

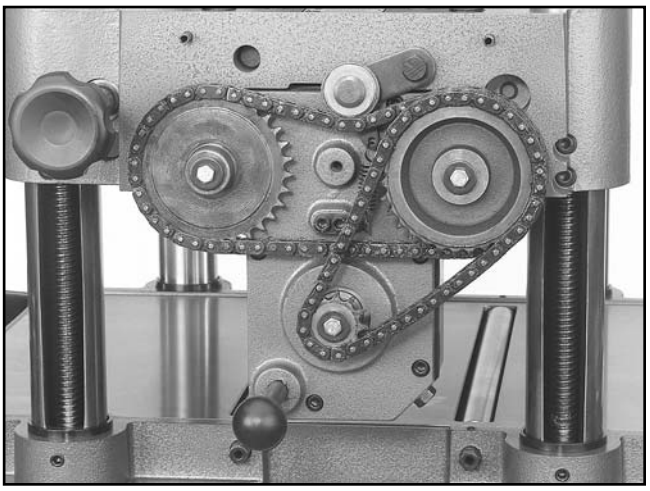


Figure 21. Gearbox.

Lubrication

Since all bearings are sealed and permanently lubricated, simply leave them alone until they need to be replaced. DO NOT lubricate them.

The following is a list of features and parts that need lubrication:

Columns/Lead Screws—The four columns should be lubricated with light machine oil once a week. The four lead screws should be lubricated with general purpose grease once a month. See **Figure 22**.

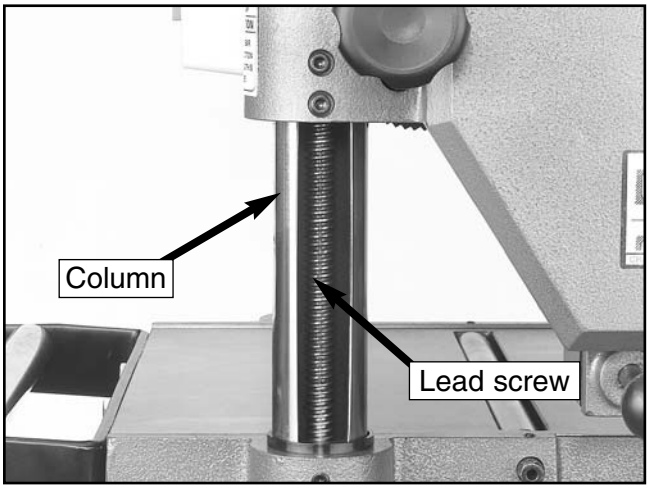


Figure 22. Columns and lead screws.

Worm Gear—The worm gear should be inspected monthly and lubricated when needed. Remove the worm gear box to inspect. See parts diagram for location.

Chain—The table height adjustment chain should be inspected monthly and lubricated when needed. A good quality bicycle chain lubricant works well for periodic lubrication.

Gear Box—Gear box oil should be drained after the first 20 hours of operation. See **Figure 23 & 24**. Replace with 80W-90 gear oil. Inspect levels periodically and change yearly. Replace gear oil more frequently under heavy use. Fill until oil reaches the top of the filler plug port for correct oil level.

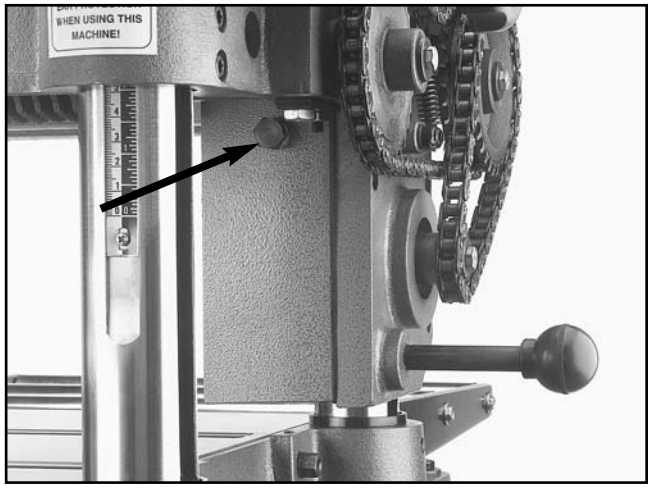


Figure 23. Gearbox fill point.

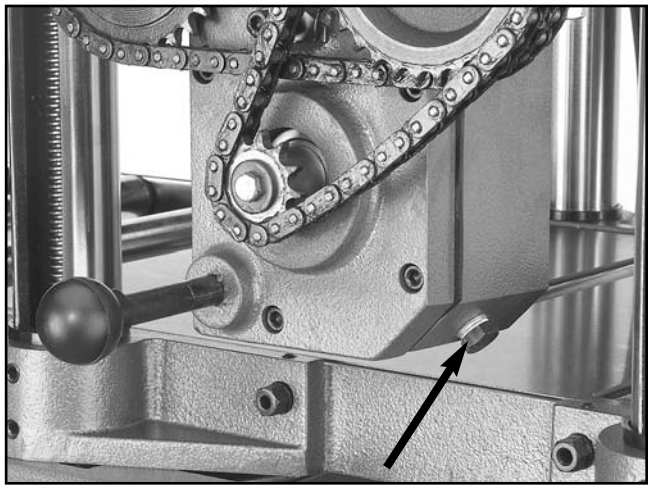


Figure 24. Gearbox oil drain point.

Drive Chain—The drive chain should be inspected and lubricated monthly. Check the sprocket, the chain and the cotter pin during inspection. Use a general purpose grease. Some chains will have master links instead of cotter pins.

Feed Rollers—The infeed/outfeed pressure setscrews double as lubrication ports for the rollers. See **Figure 25**. Add 1-2 drops of light machine oil to all ports before each use. Daily lubrication of the feed rollers is crucial to the operation of your planer. Lubricate before start-up. Apply a light oil, making sure that the lubricant penetrates the bearing.

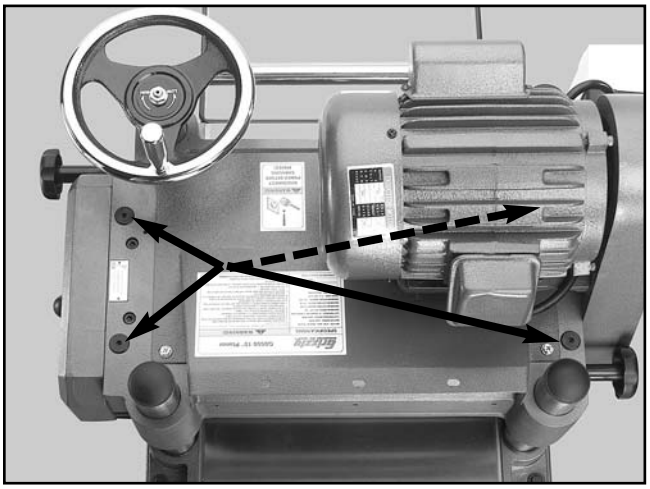


Figure 25. Feed roller lubrication points.

Planing Difficulties

The species of wood, as well as condition, will affect planing ability. The harder the wood, the more difficult it will be to plane. Below, we have included below, a list of wood characteristics you may encounter when planing. The following descriptions of defects will give you some possible answers to problems you may encounter while planing different materials. Possible solutions follow the descriptions.

Chipped Grain—Usually a result of cutting against the grain, or planing wood with knots or excessive amount of cross grain. Chipped grain can also be caused by dull knives or misaligned chipbreaker. Often, chipped grain can be avoided by slowing down the feed rate and by taking shallow cuts. If those options do not work, inspect your lumber and determine if its grain pattern is causing the problem. If the wood does not show substantial crossgrain, inspect your knives for sharpness and inspect the chipbreaker for proper alignment. See the Adjustment Section.

Fuzzy Grain—Usually caused by surfacing lumber with too high of a moisture content. Sometimes fuzzy grain is a characteristic of some woods, such as basswood. Fuzzy grain can also be caused by dull knives or an incorrect grinding bevel. Check with a moisture meter. If moisture is greater than 20%, sticker the wood and allow to dry. Otherwise, inspect knife condition.

Glossy Surface—Usually caused by dull knives taking shallow cuts at a slow feed speed. Surface gloss will usually be accompanied by overheating. Often, lumber will be scorched and eventually damage to knives will occur. If knives are sharp on inspection, increase feed speed or cutting depth.

Snipe—Occurs when board ends have more material removed than the rest of the board. Usually caused when one or both of the bed rollers are set too high. Can also be caused by the chipbreaker or pressure bar being set too high. However, small amount of snipe is inevitable.

Snipe can be minimized by proper adjustment of the planer components, but complete removal of snipe is extremely unlikely. More likely, you will be able to reduce it to a tolerance of .002". If snipe under that level is a problem, consider planing lumber longer than your intended work length and cut off the excess after planing is completed.

Uneven Knife Marks—Uneven knife marks can occur when the chipbreaker is set too high. Inspect cutterhead bearings if re-adjustment of the chipbreaker fails to remedy the situation.

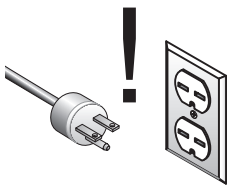
Chatter Marks—Usually caused by incorrect chipbreaker and pressure bar setting heights. Chatter marks can also be caused by running a narrow wood piece through the planer at either the right or left end of the cutterhead. Chatter, like uneven knife marks, will show in the form of a "washboard" look. Chatter marks are more likely to be inconsistent in appearance than uneven knife marks.

Wavy Surface—Caused by poor knife height adjustment, a wavy surface appears when one knife is taking deeper cuts than the rest of the knives. Remedy by resetting the knives to a tolerance within 0.003" of one another.

Pitch & Glue Build-up—Glue and resin build-up on the rollers and cutterhead will cause overheating by decreasing cutting sharpness while increasing drag in the feed mechanism. The result can include scorched lumber as well as uneven knife marks and chatter.

Chip Marks—Occur when chips are not properly expelled from the cutterhead. The knives catch the chips and drag them across the lumber being planed. Chips tend to be random and non-uniform (as compared to chipped grain). Can be caused by exhaust blockage or too much room between the cutterhead and chip deflector. Using a dust collection system in combination with the planer can help reduce chip marks. Inspect the chip deflector and readjust (as described earlier in the text).

SECTION 8: SERVICE ADJUSTMENTS



⚠WARNING

Always disconnect power to the machine before performing service adjustments. Failure to do this may result in serious personal injury.

About Service

This section is designed to help the operator with adjustments that were made at the factory and that might also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustments arise that are not described in this manual, then feel free to call the Grizzly Service Department at (570) 546-9663.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.

Gauge Blocks

Before attempting to adjust the table, you will need to construct a gauge block. See **Figure 26**. Do not use common 2x4 material. Use a hard wood material like maple or oak. A pattern for this gauge block has been provided for you on **page 48** of this manual.

A good alternative is to use a Rotocator **Figure 27**. Use the Rotocator whenever the instructions call for use of the gauge block or feeler gauge. Refer to the current Grizzly catalog for rotocators.

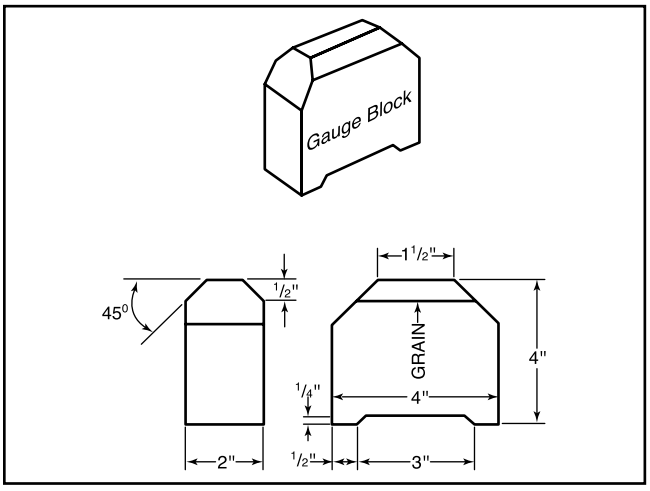


Figure 26. Gauge block specifications.

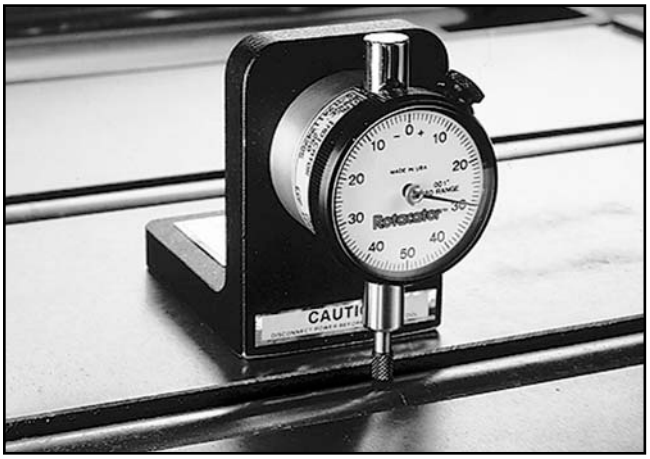


Figure 27. Rotocator.

Table Adjustment

It is important that the cutterhead is parallel to the table to plane stock perfectly square.

To check the table alignment:

1. **Disconnect the machine from the power source!**

2. Place the gauge block on the table under one end of the cutterhead.

3. Turn the handwheel to raise the table until the block barely touches the cutterhead body. **The block should not be touching the knives.** See Figure **28**.

4. Slide the block toward the opposite side of the cutterhead. Use a feeler gauge to measure the width of the gap, if any, between the top of the block and the bottom of the cutterhead. If there is a gap, make a note, reading the distance from the feeler gauge.

5. If the block wedges tightly between the table and cutterhead when shifting from one side to the other, repeat **steps 1** through **3** above, but start from the opposite end of the cutterhead.

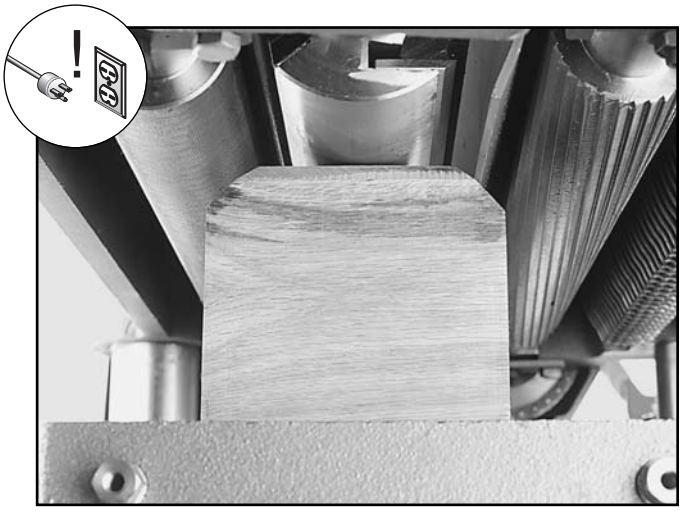


Figure 28. Setting the outfeed table height.

— If the gap difference from one side to the other is equal to or less than 0.004", no further adjustment is necessary.

— If the gap difference from one side to the other is greater than 0.004", but less than 0.016", go to **step 5**.

If the gap difference from one side to the other is greater than 0.016", the table raising chain under the planer base will need to be adjusted. Please call our Customer Service number for chain adjustment instructions.

To adjust for gap differences:

6. Determine which side of the table must be raised to correct the gap.

7. Locate the two cap screws in the table casting for each of the columns. **See Figure 29**. Loosen both sets of cap screws for each column on the side you wish to adjust.

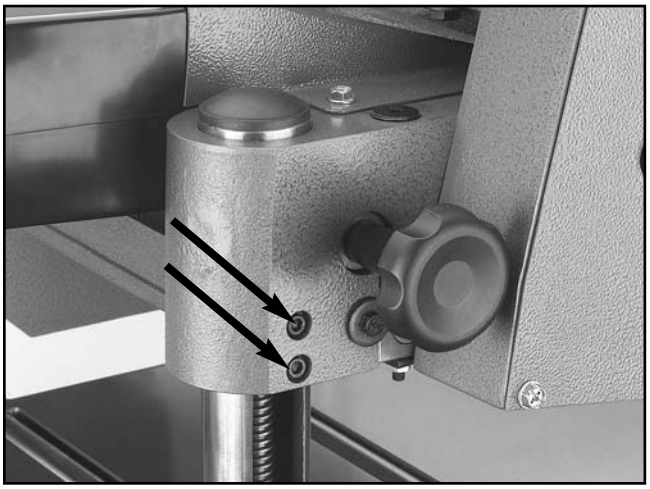


Figure 29. Cap screws for column adjustment.

8. Push down or pull up the table in the desired direction. Hold the table in position and retighten the cap screws.

9. Recheck the table to cutterhead parallelism again. Repeat **steps 1- 8** until the deviation is less than 0.004".

Thickness Scale

The thickness scale, located below the handwheel, can be adjusted for accuracy. However, material must be run through the machine to adjust the thickness scale. Make certain you have followed the directions in the Operations Section for test running before attempting to make these adjustments.

To adjust the scale:

1. Adjust the cutterhead height to the approximate thickness of your test lumber. Measure the lumber with calipers to determine its exact thickness.

2. Move the cutterhead to 1/16" under the thickness of your lumber and feed your test board through the planer.

3. Turn the handwheel one half rotation and run the board through once more. Turn the board over and repeat.

4. Measure the board again and compare your results with the scale. If there is a discrepancy, loosen the scale adjustment screw and correct the position. See **Figure 30**.

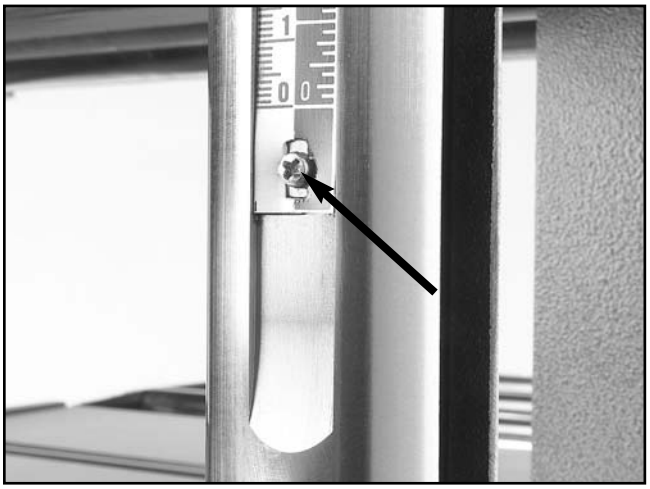


Figure 30. Screw for column adjustment.

Knife Inspection

The Model G0550/G0551 Planer has a three-knife cutterhead. The cutterhead is located in the head casting and rotates on two sealed bearings. No lubrication is needed for the life of the bearings.

Because of normal use and wear, the knives must be periodically sharpened, replaced or adjusted. Adjustment from the factory must also be checked prior to use due to possible movement during shipment.

To inspect the knives:

1. **Disconnect the machine from the power source!**

2. Lower the table and place the gauge block or a Rotocator under one end of the cutterhead**.**

3. Remove the V-Belt cover and carefully rotate the belts to turn the cutterhead until the first knife is at bottom dead center. Adjust the cutterhead height until the knife barely touches the top of gauge block. Note—*Rock the cutterhead back and forth to determine bottom dead center.*

4. Slide the gauge block to the opposite side of the cutterhead and check the same knife, rocking back and forth to determine bottom dead center.

   — If the knife does not contact the gauge block, use a feeler gauge to determine the difference between one side and the other. See **Figure 31**.

   — If the knife bottoms out on the gauge block, repeat **steps 1-3**, but start on the opposite side of the cutterhead**.**

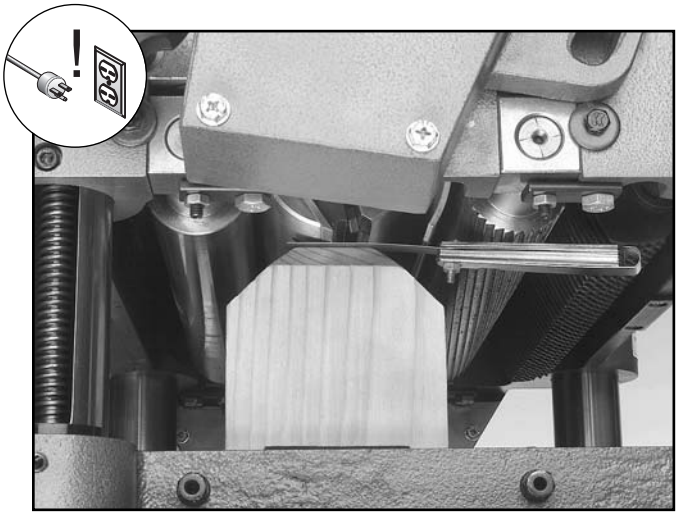


Figure 31. Using the feeler gauge to measure the gap.

5. The variation between one side and the other should not be greater than 0.004". Repeat **steps 1-4** on the other two knives. Again, the variation between all three knives should not be greater than 0.004".

Once you have completed inspection on all three knives, you will able to determine whether or not there is a need to adjust the knives in the cutterhead. Proceed to the appropriate section, depending upon whether you are using the jack screws or the springs.

⚠WARNING

When making adjustments, all three knives must be adjusted the same. DO NOT adjust one knife without adjusting the others as well. Improper knife height adjustment can result in damage to knives, poor planer performance and possible operator injury.

NOTICE

Always adjust the thickness scale after adjusting the knives.

Knife Sharpening

For the best results, it is best to have planer knives sharpened by a professional sharpening service which has the grinding and measurement equipment to assure that the knife cutting geometry is maintained at optimum levels. Knife sharpening is a procedure that requires some care and precision, otherwise, a set of blades can be easily ruined. Knives should always be ground as a set so they can be properly matched. Unequal material removal can result in an unbalanced cutterhead which can affect not only planing surface quality but ultimately the life of the cutterhead bearings.

Your planer knives can be sharpened by a blade hone. See the “Aftermarket Accessories” subsection at the back of this manual for more information.

Knife Setting

The process of setting the knives in the cutterhead will come into play whenever you sharpen or replace, or after determining that setting is necessary during the initial setup.

The knives lock into the cutterhead with wedge type gibs. Springs under each knife provide an upward pressure to help ease the setting process. Jack screws under the knives allow fine tuning to help in the setting process.

To set the knives:

1. **Disconnect the machine from the power source!**

2. Remove the upper cover to expose the cutterhead.

3. Choose a knife to begin with and loosen the gib bolts just enough until the springs push the knife upward.

Figure 32 illustrates the features of the cutterhead that are mentioned in this section.

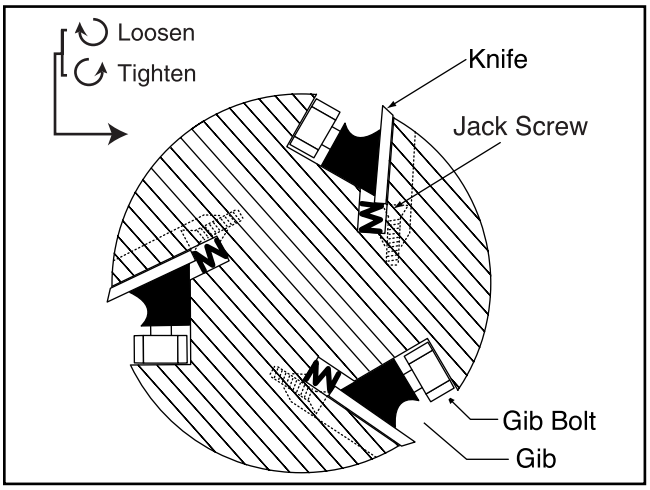


Figure 32. Proper knife setting jig placement.

4. Place the knife setting jig over the knife on the cutterhead as shown in **Figure 33**. The knife setting jig will push the knife into position in the cutterhead.

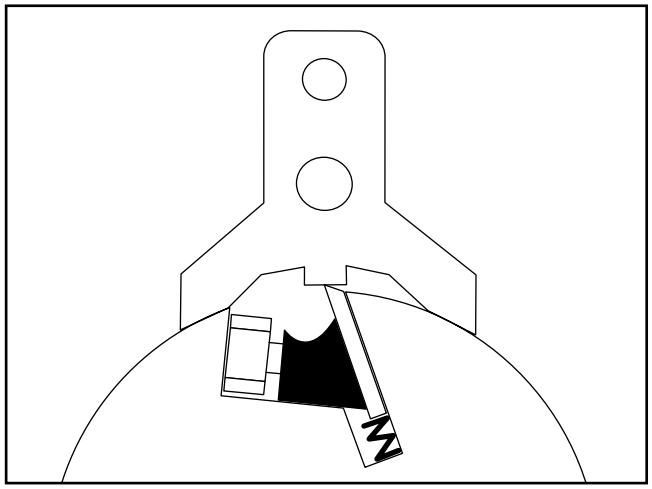


Figure 33. Proper knife setting jig placement.

5. While holding the position of the knife setting jig, adjust the jack screws, located on each end of the knife, until they make contact with the bottom of the knife.

6. While holding the position of the knife setting jig, tighten the gib bolts down again in the cutterhead (**Figure 34**). Tighten the bolts evenly from the middle, working toward the ends.

7. Repeat these steps for the other two knives.

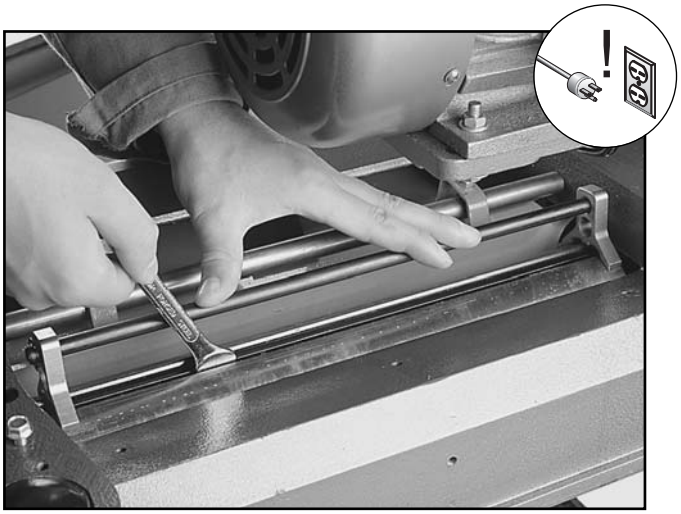


Figure 34. Tightening gib bolts in cutterhead.

Chip Breaker

The chip breaker is located on the top side of the planer and extends down around the front of the cutterhead. Its function is to prevent tear-out or deep, unregulated gouging as the knives remove material. The chip breaker works by breaking the woodchips as they are being cut by the cutterhead. The chip breaker also deflects and expels the woodchips away from the surface of the board and out of the planer.

To check the chipbreaker:

1. **Disconnect the machine from the power source!**

2. Ensure that the knives are properly adjusted.

3. Place the gauge block on the table directly under the cutterhead.

4. Using a 1mm feeler gauge between the gauge block and the cutterhead, raise the table until one of the knives just touches the feeler gauge. Rotate the cutterhead by turning the V-belts to be sure the knife is at bottom dead center.

5. Lock the table by tightening the table lock knobs.

6. Remove the feeler gauge and slide the gauge block under the chip breaker. **See Figure 35**. The chip breaker should just touch the top of the gauge block. Slide the gauge block to the opposite end of the chip breaker and check it in the same manner.

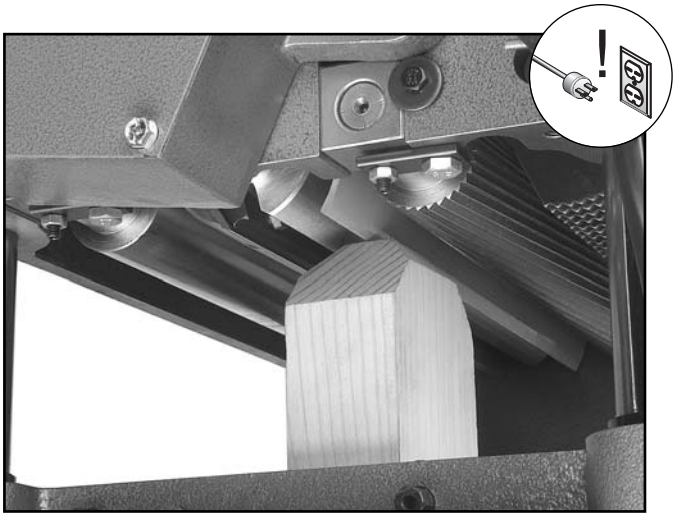


Figure 35. Gauge block under chip breaker.

To adjust the chip breaker:

1. **Disconnect the machine from the power source!**

2. If an adjustment is necessary, loosen the locknuts and turn the setscrews. See **Figure 36**. Stop turning when the bottom of the chip breaker just touches the gauge block.

3. Tighten both locknuts.

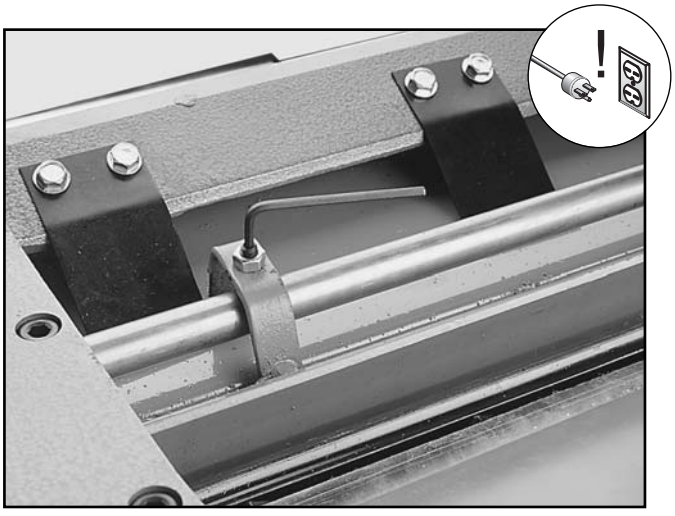


Figure 36. Chip breaker height adjustment.

Feed Roller Height

The infeed and outfeed rollers move the lumber through the planer, and press the lumber flat against the planer table.

Set the infeed and outfeed rollers to 0.02"-0.04" below the cutterhead knife edge at bottom dead center.

To check roller height:

1. **Disconnect the machine from the power source!**

2. Lower the table so the gauge block will fit under one side of the infeed roller.

3. Raise the table until the gauge block barely touches the infeed roller. See **Figure 37**. Do not change the position of the table.

4. Slide the gauge block over so it is under the edge of one of the knives. Turn the cutterhead until one of the knives is at bottom dead center over the gauge block.

5. Measure the clearance between the top of the gauge block and the edge of the knife with a feeler gauge. Note the measurement indicated on the feeler gauge.

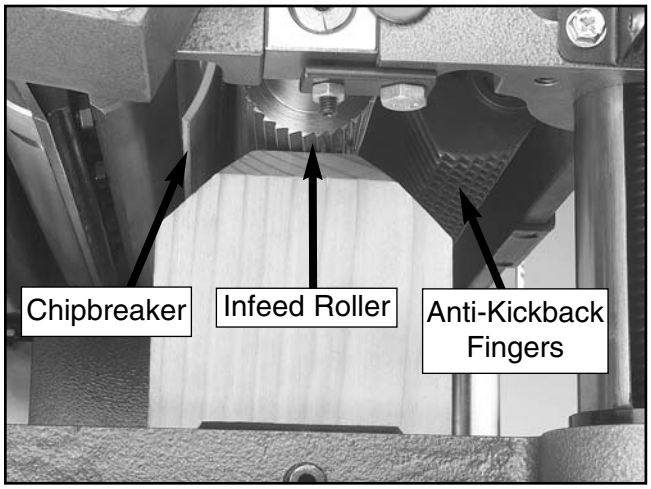


Figure 37. Feed roller height inspection.

6. Repeat **steps 1-5** for the opposite side of the roller. Repeat all steps for the outfeed roller.

Feeler gauge measurement should be between 0.02"- 0.04"on the infeed and outfeed roller at bottom dead center.

To adjust roller height:

1. Remove the drive chain cover to access the roller adjustments on the drive chain side of the planer. A single socket head cap screw holds the drive chain cover on. The belt side adjustments are already accessible.

2. Loosen the roller adjustment check nuts and turn the roller height setscrews to change the height of the roller as needed. **See Figure 38**.

3. Check the roller height according to the above instructions. Continue turning the setscrew until the roller is properly adjusted.

4. When the roller is set in the correct position, retighten the check nuts you loosened in **step 2** above.

5. Check your settings one last time and repeat **steps 1-4** if necessary.

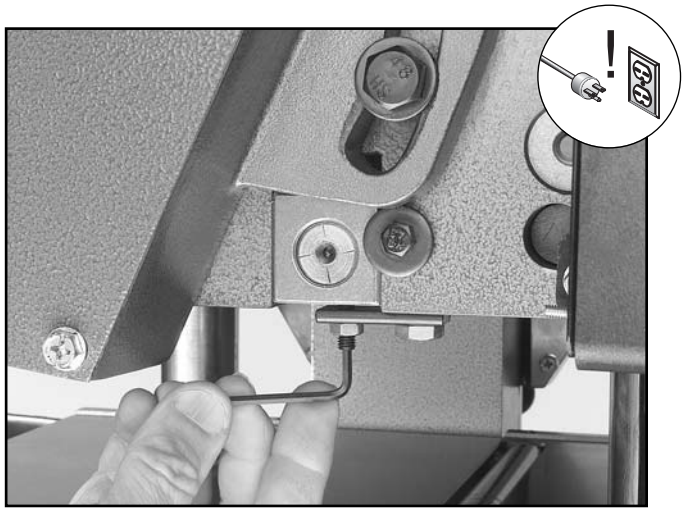


Figure 38. Feed roller height adjustment.

Bed Rollers

The bed rollers ease stock movement through the planer. The height of the bed rollers will vary depending on the types of wood you will be planing. When planing rough stock, set the rollers slightly high to keep the lumber from dragging along the bed; however, snipe may be unavoidable. Smooth lumber should be planed with the rollers set just above the plane of the table. This will minimize snipe.

To adjust the bed rollers:

1. Ensure that power is disconnected and lay a high quality straightedge across both table rollers. Use a try square to keep the straightedge perpendicular to the table.

2. Use a feeler gauge to measure the clearance between the bottom of the straight edge and the table. Ideal clearance is between 0.006" and 0.002". Measure in several places. This measurement must be consistent across the entire table. See **Figure 39.**

Figure 39. Inspecting bed roller height.

3. Loosen the setscrews on both sides of each bed roller. **See Figure 40.**

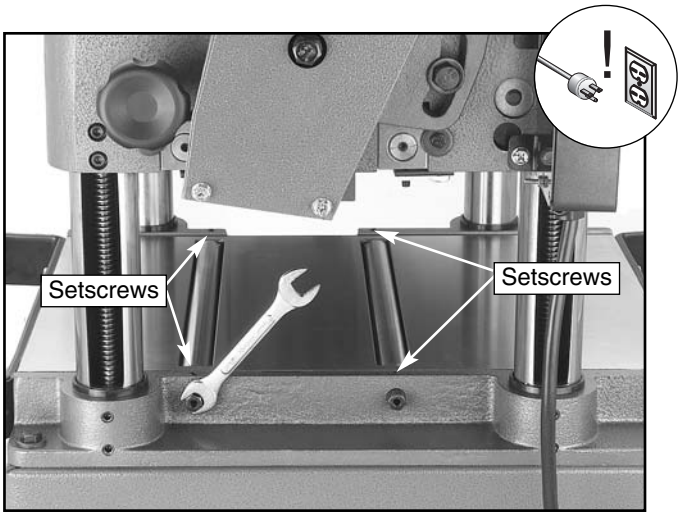


Figure 40. Adjusting bed roller height.

4. Use a wrench to turn the eccentric shafts that adjust roller height. Stop turning when the table rollers are at the proper height.

5. Once your roller heights are correct, retighten all the setscrews.

6. Check the height of the table rollers. Repeat **steps 1-5** until the bed rollers are properly set.

7. Spin the bed rollers to ensure free movement.

Feed Roller Pressure

To be effective, the infeed and outfeed rollers must put pressure on the workpiece as it feeds through the planer. Too little pressure results in slipping boards, too much pressure results in jamming.

Experiment with the best pressure settings for your work situations. Some rough cut lumber will feed through with relatively few problems, while other lumber will have more difficulty.

Adjusting roller pressure does not affect height.

To adjust roller pressure:

1. **Disconnect the machine from the power source!**

2. Ensure that knives and feed rollers are set correctly.

3. Unscrew the three regular pressure setscrews on top of the planer body. See **Figure 41**.

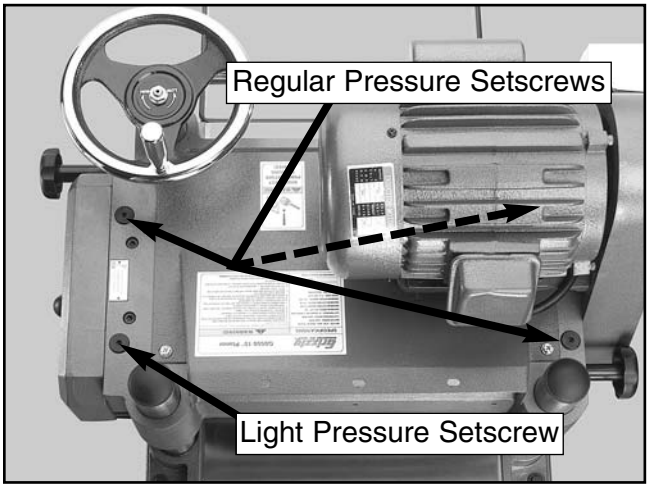


Figure 41. Roller pressure setscrews.

4. Remove the springs that are in the setscrew holes. See **Figure 42**.

5. Check for any dirt or grit, and clean the springs and setscrews if dirty.

6. Screw the three regular-pressure setscrews back in until they are flush with the top of the head casting.

7. Screw the light pressure setscrew (**Figure 42**) until it is approximately ¼" above the head casting. The feed chain applies additional tension to the right side of the outfeed roller, so the pressure added by the setscrew need not be as high.

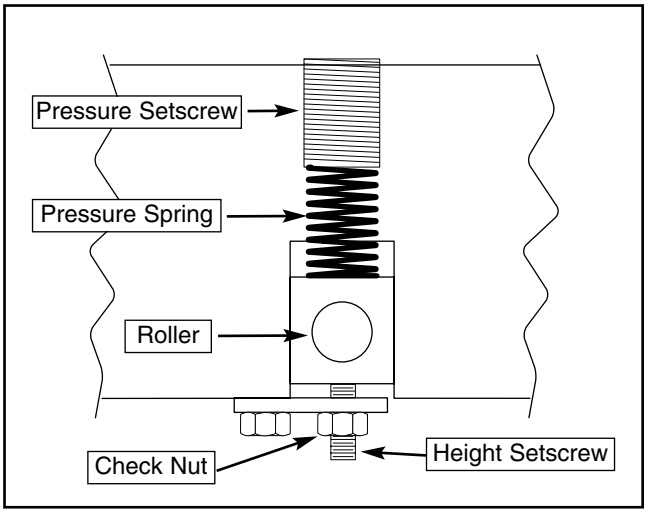


Figure 42. Roller pressure assembly.

Chip Deflector

The chip deflector keeps chips from falling onto the outfeed roller. It is the orange plastic plate located under the top cover.

The beveled edge of the chip deflector should be properly adjusted according to your dust collection setup. However, if the chip deflector is set too close to the knives, the rotating cutterhead may pull it in and destroy it.

To adjust the chip deflector:

1. **Disconnect the machine from the power source!**

2. Loosen the three deflector mounting bolts. See **Figure 43**. Make sure the beveled edge of the deflector faces the cutterhead.

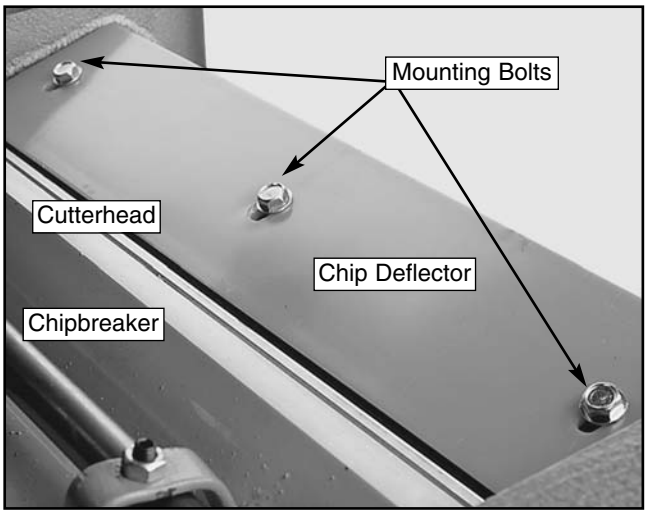


Figure 43. Chip deflector access.

— The edge of the chip deflector should be 1/16" away from the knife edge if a dust collection system is not installed on your planer.

— The edge of the chip deflector should be ¼" away from the knife edge if a dust collection system is in place on your planer.

3. Tighten the chip deflector mounting bolts and mount the upper cover back onto the planer.

SECTION 9: REFERENCE INFO

General

This section contains the following subsections for the Model G0550/G0551: aftermarket accessories, data sheets, parts diagrams and list, troubleshooting, wiring diagrams, gauge block design, and warranty/return information.

If you need parts or help in assembling your machine, or if you need operational information, call the service department at (570) 546-9663. Trained service technicians will be glad to help you.

If you have any comments regarding this manual, please write to Grizzly at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the Service Department at the location listed below.

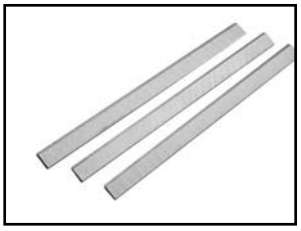
Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com.

Aftermarket Accessories

To order any of the aftermarket accessories below, find the model number in bold and call our customer service line 24 hours a day at 1-800-523-4777.

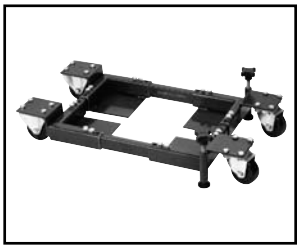
Replacement Knives—Model G1196

Replace your old planer knives and get your machine cutting like new again with these high speed steel replacement knives.



SHOP FOX® Mobile Base—Model G8683

Make your planer mobile with this popular patented mobile base.

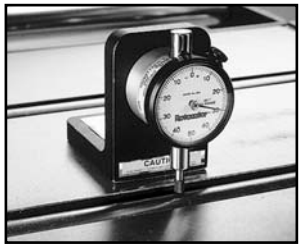


Planer Pals—See The Current Grizzly Catalog For Model #s.

These patented jigs are remarkably simple to use an hold knives securely in place while you tighten them in the cutterhead. They also allow you to shift nicked knives to avoid replacement or removal.

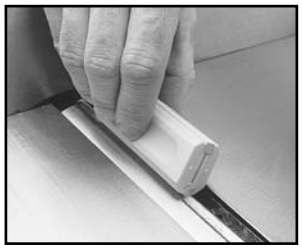
Rotocator—Model G1738

The Rotacator® has a magnetic base and is used to adjust settings on any planer. Infeed and outfeed rollers, pressure bars, feed-bed rollers, chipbreaker,etc., can be adjusted very quickly and accurately.



Planer/Jointer Blade Hone—Model G3631

Add a razor hone to your planer and jointer knives with this hand-held sharpening device.



Grizzly Industrial, Inc.®

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

GRIZZLY MODEL G0550 15" PLANER

Design Type .....Bench Model

Overall Dimensions:

Table Size.....14 7/8" x 20"
Height w/ Stand .....53"
Overall Length .....48"
Overall Width.....28"
Shipping Weight.....460 lbs.
Net Weight .....410 lbs.
Foot Print .....25" x 25"
Crate Size .....22½"L x 30"W x 29"H

Capacities:

Maximum Depth of Cut.....⅛"
Maximum Width of Cut ..... 14 7/8"
Maximum Cutting Height .....6⅛"
Minimum Stock Thickness.....3/16"
Minimum Stock Length .....8"
Cutterhead Speed .....5000 RPM
Cuts per Minute 15,000
Cuts per Inch..... 63 & 78
Feed Speeds .....16 & 20 FPM

Construction:

Table .....Precision Ground Cast Iron
Infeed Roller .....Spiral Serrated
Outfeed Roller .....Machined Steel
Power Transfer to Feed Rollers:.....Gearbox & Chain
Cutterhead Assembly .....Steel
Cutterhead .....One piece machined shaft; 3 Knife Slots w/ Sealed Ball Bearings

Motor:

Type .....TEFC Capacitor-Start Induction
Horsepower.....2 HP
Phase / Voltage .....Single Phase / 220 V
Amps 12A
Cycle / RPM.....60 Hertz / 3450 RPM
Switch.....Magnetic With Thermal Overload Protector
Power Transfer to Cutterhead .....Triple V-Belt
Bearings .....Sealed & Permanently Lubricated Ball Bearings

Features:

Stand.....Open Style
Roller Extension Tables .....3 Adjustable Rollers
Cutterhead Movement .....Handwheel & 4 Chaindriven Leadscrews
Table Locks .....Two Positive
Chip Chute .....4" Outlet
Bed Rollers .....2 Adjustable
Knife Type / Size / Adjustment .....3 HSS / 15" x 1" x ⅛" / Jack-screws and Springs
.....Drive Gears Run In Oil Bath
.....Vertical Scale Calibrations Inch/Metric

Specifications, while deemed accurate, are not guaranteed.

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

GRIZZLY MODEL G0551 15" PLANER

Design Type .....Bench Model

Overall Dimensions:

- Table Size .....14 7/8" x 20"
- Height w/ Stand .....53"
- Overall Length .....48"
- Overall Width .....28"
- Shipping Weight .....560 lbs.
- Net Weight .....450 lbs.
- Foot Print .....21" x 21"
- Crate Size .....30¾"L x 30"W x 48½"H

Capacities:

- Maximum Depth of Cut .....⅛"
- Maximum Width of Cut ..... 14 7/8"
- Maximum Cutting Height .....6⅛"
- Minimum Stock Thickness .....3/16"
- Minimum Stock Length .....8"
- Cutterhead Speed .....5000 RPM
- Cuts per Minute 15,000
- Cuts per Inch ..... 63 & 78
- Feed Speeds .....16 & 20 FPM

Construction:

- Table .....Precision Ground Cast Iron
- Infeed Roller .....Spiral Serrated
- Outfeed Roller .....Machined Steel
- Power Transfer to Feed Rollers: .....Gearbox & Chain
- Cutterhead Assembly .....Steel
- Cutterhead .....One piece machined shaft; 3 Knife Slots w/ Sealed Ball Bearings

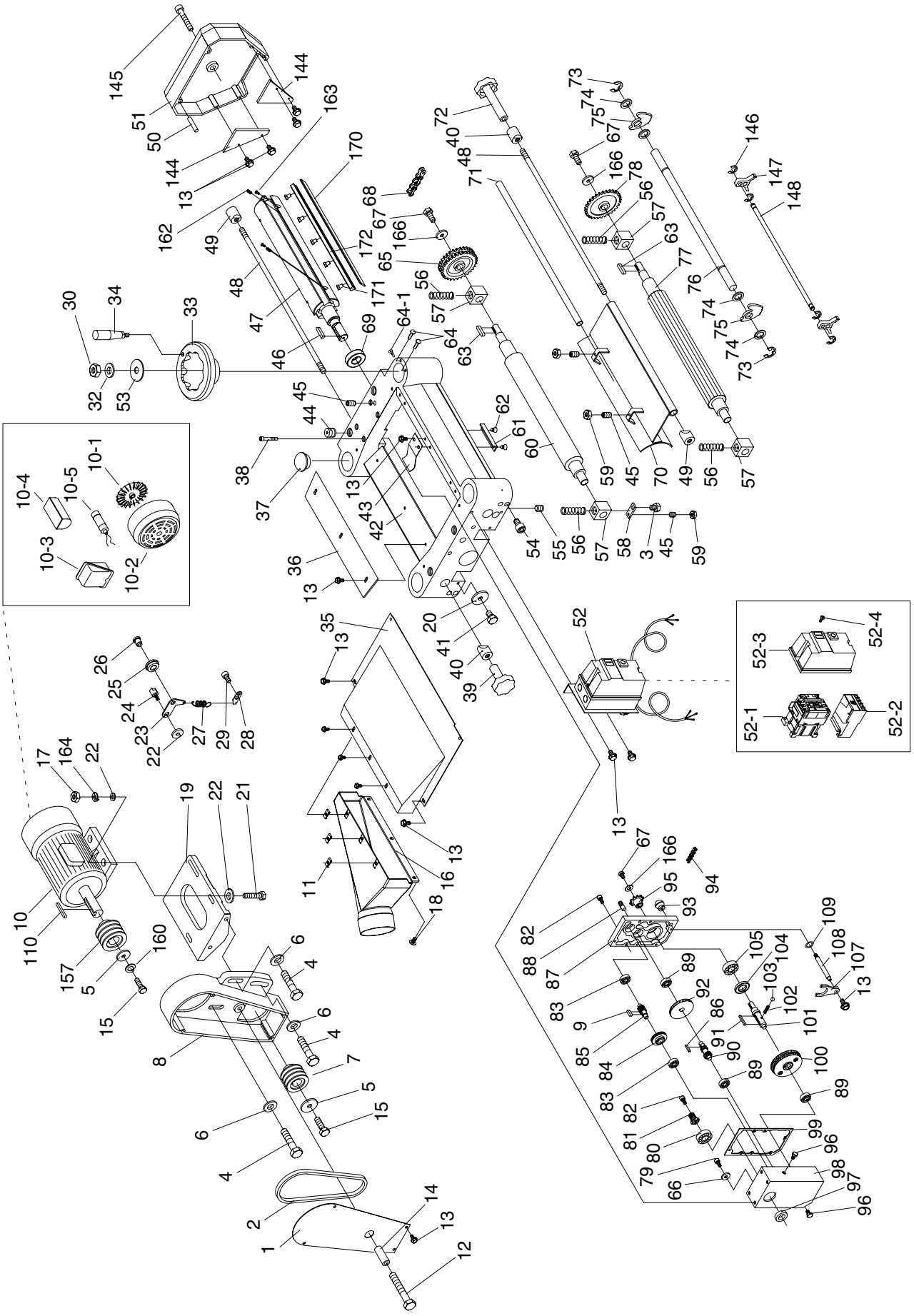
Motor:

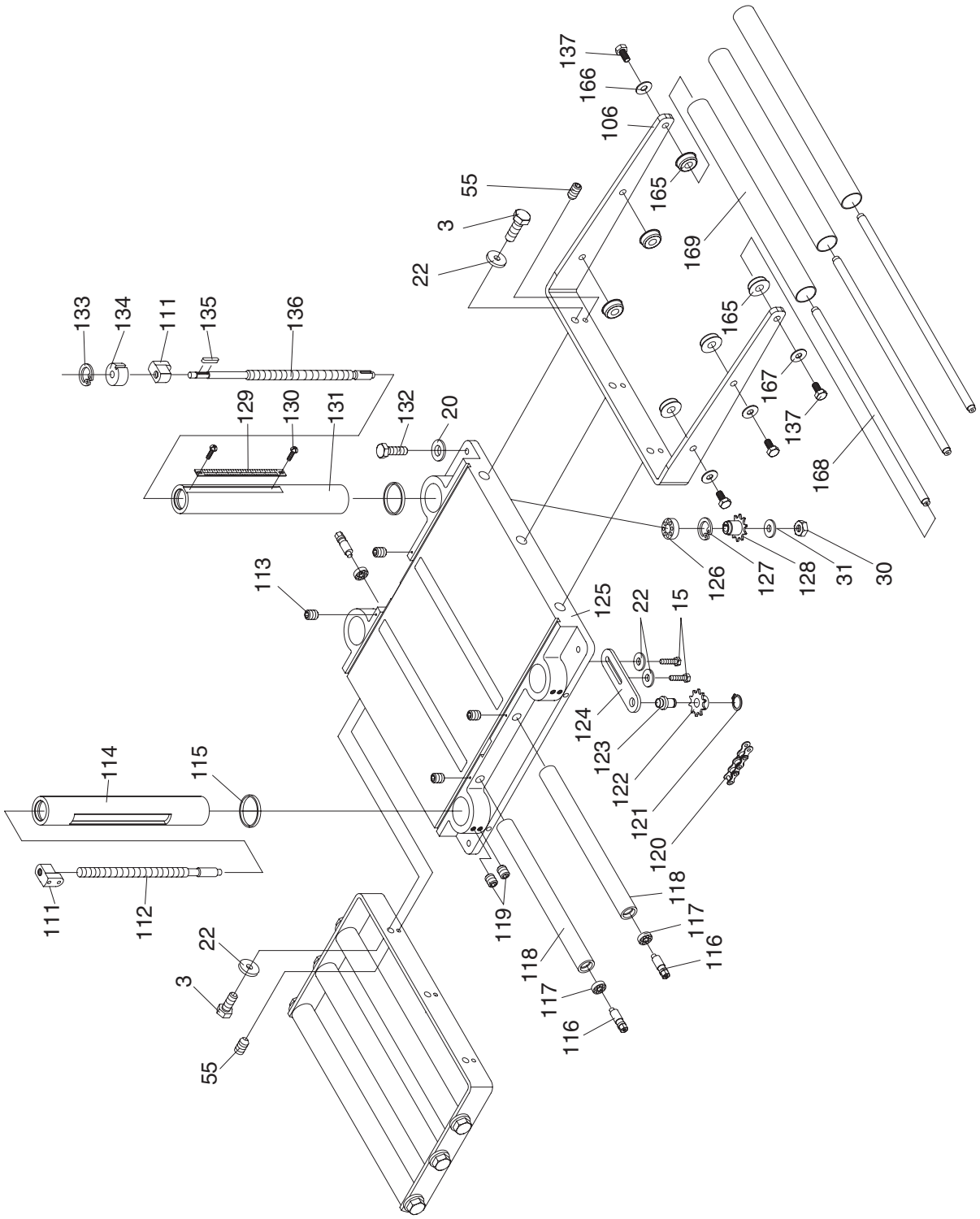
- Type .....TEFC Capacitor-Start Induction
- Horsepower .....3 HP
- Phase / Voltage .....Single Phase / 220 V
- Amps 18A
- Cycle / RPM .....60 Hertz / 3450 RPM
- Switch .....Magnetic With Thermal Overload Protector
- Power Transfer to Cutterhead .....Triple V-Belt
- Bearings .....Sealed & Permanently Lubricated Ball Bearings

Features:

- Roller Extension Tables .....3 Adjustable Rollers
- Cutterhead Movement .....Handwheel & 4 Chaindriven Leadscrews
- Table Locks .....Two Positive
- Chip Chute .....4" Outlet
- Bed Rollers .....2 Adjustable
- Knife Type / Size / Adjustment .....3 HSS / 15" x 1" x ⅛" / Jack-screws and Springs
- .....Drive Gears Run In Oil Bath
- .....Vertical Scale Calibrations Inch/Metric
- .....Powder Coated Paint on Cabinet

Specifications, while deemed accurate, are not guaranteed.

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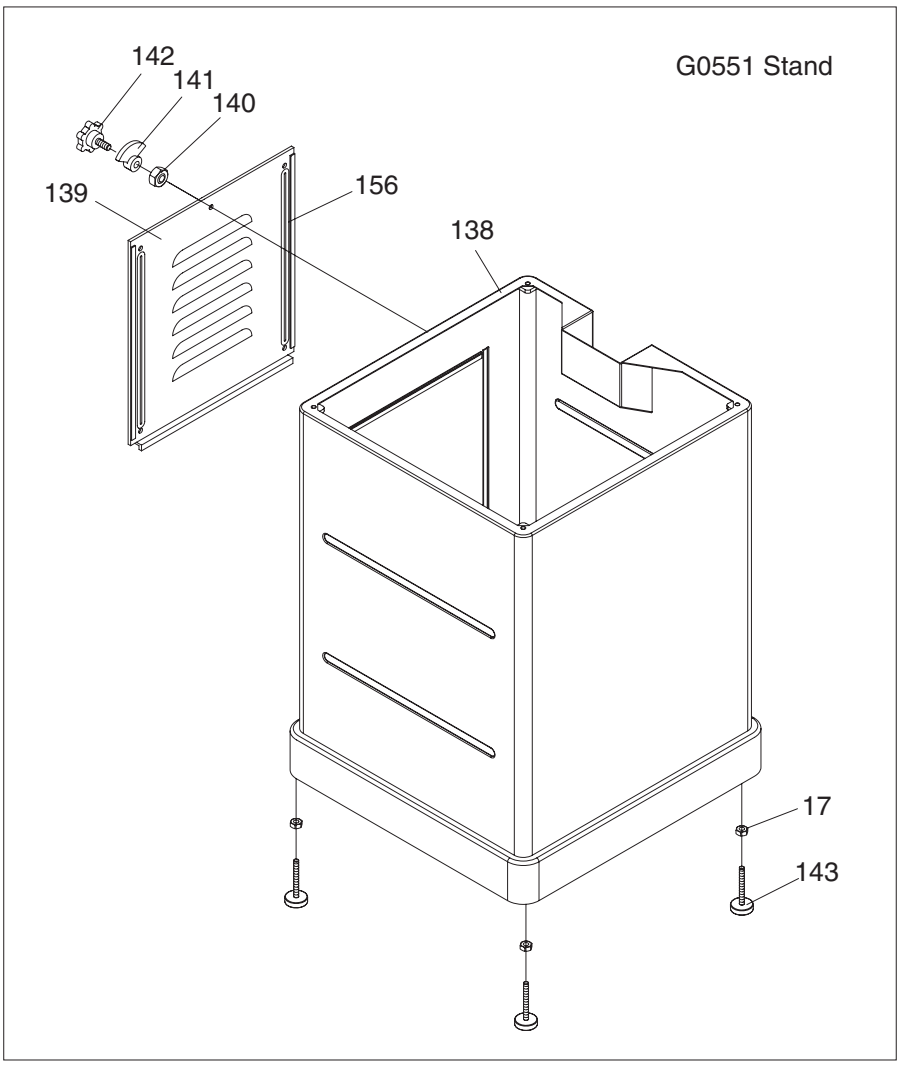
G0551 Stand
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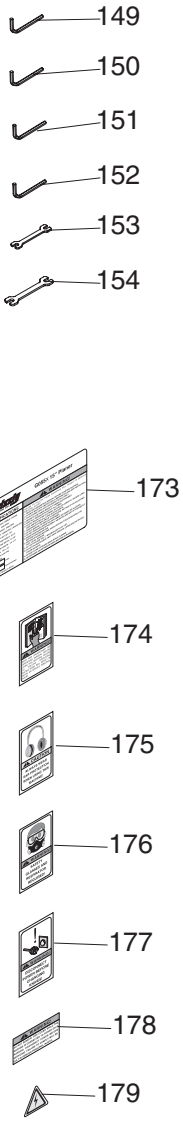
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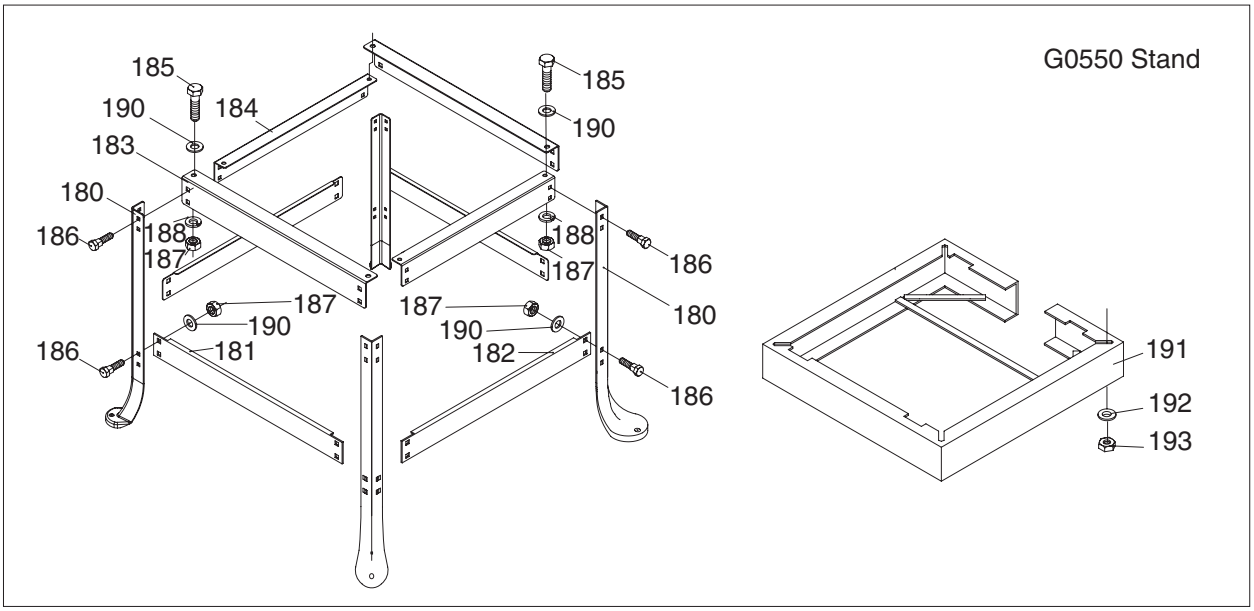
G0550 Stand
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REF	PART #	DESCRIPTION
1	P0550001	PULLEY COVER
2	PVM27	V-BELT M-27 3L270
3	PB09M	HEX BOLT M8-1.25 X 20
4	PB01M	HEX BOLT M10-1.5 X 30
5	P0550005	SPECIAL WASHER
6	PW04M	FLAT WASHER 10MM
7	P0550007	CUTTERHEAD PULLEY
8	P0550008	BELT HOUSING
9	PK10M	KEY 5 X 5 X 12
10	P0550010	2 HP MOTOR (G0550)
10	P0551010	3 HP MOTOR (G0551)
10-1	P0550010-1	MOTOR FAN (G0550)
10-1	P0551010-1	MOTOR FAN (G0551)
10-2	P0550010-2	MOTOR FAN COVER (G0550)
10-2	P0551010-2	MOTOR FAN COVER (G0551)
10-3	P0550010-3	WIRING BOX (G0550)
10-3	P0551010-3	WIRING BOX (G0551)
10-4	P0550010-4	CAPACITOR COVER (G0550)
10-4	P0551010-4	CAPACITOR COVER (G0551)
10-5	P0550010-5	S CAPACITOR500M125V(G0550)
10-5	P0551010-5	S CAPACITOR500M125V(G0551)
11	P0550011	CLIP
12	PB13M	HEX BOLT M10-1.5 X 80
13	PFB01M	FLANGE BOLT M6-1 X 12
14	P0550014	SPACER
15	PB07M	HEX BOLT M8-1.25 X 25
16	P0550016	DUST CHUTE
17	PN03M	HEX NUT M8-1.25
18	PS14M	PHLP HD SCR M6-1 X 12
19	P0550019	MOTOR PLATE
20	PW01M	FLAT WASHER 8MM
21	PB118M	HEX BOLT M8-1.25 X 45
22	PW01M	FLAT WASHER 8MM
23	P0550023	CHAIN TENSIONER
24	P0550024	SHAFT
25	P0550025	TENSION WHEEL
26	P0550026	SHAFT
27	P0550027	SPRING
28	P0550028	HANGER
29	PSB04M	CAP SCREW M6-1 X 10
30	PN08M	HEX NUT M10-1.25
31	PW04M	FLAT WASHER 10MM
32	PW04M	FLAT WASHER 10MM
33	P0550033	HEIGHT HANDWHEEL
34	P0550034	HANDLE
35	P0550035	UPPER COVER
36	P0550036	CHIP DEFLECTOR
37	P0550037	COLUMN CAP
38	PSB05M	CAP SCREW M8-1.25 X 50
39	P0550039	LOCKING KNOB
40	P0550040	GIB
41	PB02M	HEX BOLT M6-1 X 12

REF	PART #	DESCRIPTION
42	P0550042	HEAD CASTING
43	P0550043	CHIP BREAKER SPRING
44	P0550044	TENSIONING SETSCREW
45	PSS11M	SET SCREW M6-1 X 16
46	PK09M	KEY 8 X 8 X 36
47	P0550047	CUTTERHEAD
48	P0550048	LOCKING ROD
49	P0550049	THREADED GIB
50	P0550050	PIN
51	P0550051	CHAIN COVER
52	P0550052	MAG SWITCH 220V, 2HP(G0550)
52	P0551052	MAG SWITCH 220V, 3HP(G0551)
52-1	P0550052-1	CONTACTOR MA-09 (G0550)
52-1	P0551052-1	CONTACTOR MA-18 (G0551)
52-2	P0550052-2	RELAY RA-20/12~18A (G0550)
52-2	P0551052-2	RELAY RA-30/18~26A (G0551)
52-3	P0550052-3	MAG SWITCH COVER (G0550)
52-3	P0551052-3	MAG SWITCH COVER (G0551)
52-4	P0550052-4	PLASTIC SWITCH SCREW
53	P0550053	DIRECTION SCALE
54	PSB01M	CAP SCREW M6-1 X 16
55	PSS14M	SET SCREW M8-1.25 X 12
56	P0550056	SPRING
57	P0550057	BUSHING BLOCK
58	P0550058	PLATE
59	PN01M	HEX NUT M6-1
60	P0550060	OUTFEED ROLLER
61	P0550061	DEPTH LIMITER
62	PFH30M	FLAT HD SCR M5-.8 X 8
63	PK01M	KEY 5 X 5 X 22
64	P9972609	RIVET 2X5
64-1	P0550064-1	POINTER
65	P0550065	SPROCKET
66	PW03M	FLAT WASHER 6MM
67	PB83M	HEX BOLT M6-1 X 16
68	P0550068	CHAIN
69	P6205	BALL BEARING 6205
70	P0550070	CHIP BREAKER
71	P0550071	CHIP BREAKER ADJUST ROD
72	P0550072	LOCKING KNOB
73	PECO5M	E-CLIP15MM
74	P0550074	SPACER
75	P0550075	ANTI-KICKBACK FINGER
76	P0550076	SHAFT
77	P0550077	INFEED ROLLER
78	P0550078	SPROCKET
79	PSB26M	CAP SCREW M6-1 X 12
80	P6204	BALL BEARING 6204
81	P0550081	GEAR
82	PSB06M	CAP SCREW M6-1 X 25
83	P6201	BALL BEARING 6201
84	P0550084	GEAR

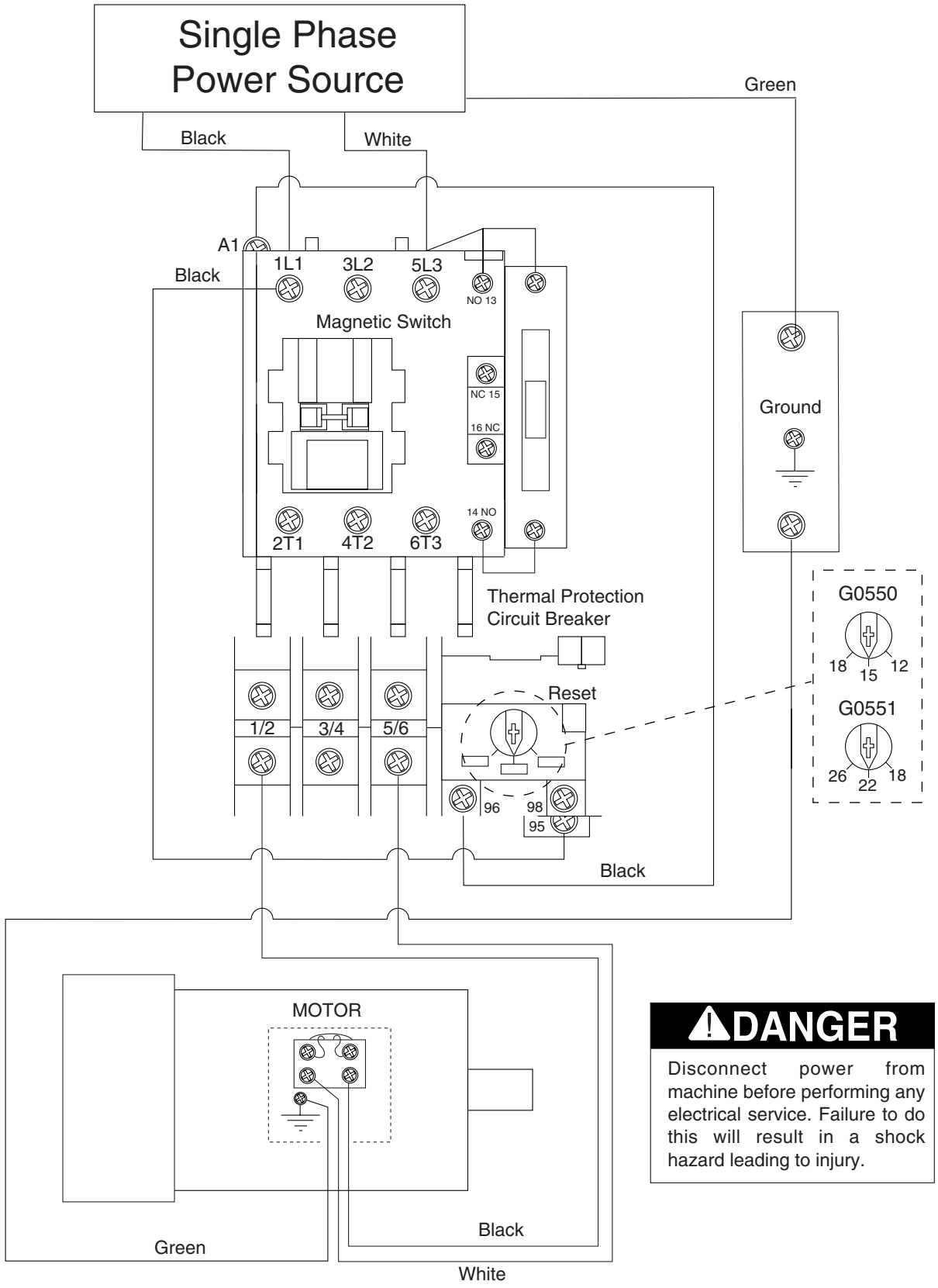
REF	PART #	DESCRIPTION
85	P0550085	GEAR AND SHAFT
86	PK06M	KEY 5 X 5 X 10
87	P0550087	GEAR CASE
88	P0550088	PIN
89	P6201	BALL BEARING 6201
90	P0550090	GEAR, 2 SPEED
91	PK11M	KEY 6 X 6 X 40
92	P0550092	GEAR
93	PSW03-1	ROUND KNOB (FEMALE)
94	P0550094	CHAIN
95	P0550095	SPROCKET
96	P0550096	OIL PLUG
97	P0550097	OIL SEAL 28 X 40 X 8
98	P0550098	GEAR BOX
99	P0550099	GASKET
100	P0550100	DOUBLE GEAR
101	P0550101	SHAFT
102	P0550102	SPRING
103	P1021128	BALL 6MM
104	P0550104	OIL SEAL 25 X 47 X 6
105	P6204	BALL BEARING 6204
106	P0550106	ROLLER FRAME
107	P0550107	SHIFTER
108	P0550108	SHIFTER SHAFT
109	P0550109	O-RING 12MM
110	PK12M	KEY 5 X 5 X 30
111	P0550111	SPINDLE NUT
112	P0550112	ELEV. LEAD SCREW, SHORT
113	PSS04M	SET SCREW M6-1 X 12
114	P0550114	COLUMN
115	P0550115	COLUMN RING
116	P0550116	TABLE ROLLER SHAFT
117	P608ZZ	BALL BEARING 608
118	P0550118	TABLE ROLLER
119	PSS13M	SET SCREW M10-1.5 X 12
120	P0550120	CHAIN
121	PR05M	EXT RETAINING RING 15MM
122	P0550122	SPROCKET
123	P0550123	SHAFT
124	P0550124	IDLER BRACKET
125	P0550125	BASE
126	P6202	BALL BEARING 6202
127	PR21M	INT RETAINING RING 35MM
128	P0550128	SPROCKET
129	P0550129	SCALE
130	PS12M	PHLP HD SCR M3-.5 X 6
131	P0550131	COLUMN
132	PB26M	HEX BOLT M8-1.25 X 30
133	PR22M	INT RETAINING RING 38MM
134	P0550134	BUSHING
135	PK48M	KEY 4 X 4 X 20
136	P0550136	ELEVATION SPINDLE, LONG

REF	PART #	DESCRIPTION
137	PB02M	HEX BOLT M6-1 X 12
138	P0551138	STAND
139	P0551139	STAND DOOR
140	PN08	HEX NUT 3⁄8-16
141	P0551141	DOOR LOCK
142	P0551142	LOCKING KNOB
143	P0551143	FOOT
144	P0550144	SAFETY HATCH
145	PSB45M	CAP SCREW M8-1.25 X 45
146	PEC10M	E-CLIP 9MM
147	P0550147	KNIFE GAUGE
148	P0550148	KNIFE GAUGE ROD
149	PAW06M	ALLEN WRENCH 6MM
150	PAW05M	ALLEN WRENCH 5MM
151	PAW04M	ALLEN WRENCH 4MM
152	PAW03M	ALLEN WRENCH 3MM
153	PWR810	8 X 10 WRENCH
154	PWR1214	12 X 14 WRENCH
156	P0551156	PANEL PAD
157	P0550157	MOTOR PULLEY
160	PLW04M	LOCK WASHER 8MM
162	P0550162	SPRING
163	P0550163	JACK SCREW M5-.8 X 12
164	PLW04M	LOCK WASHER 8MM
165	P0550165	PLASTIC ROLLER BUSHING
166	PW03M	FLAT WASHER 6MM
168	P0550168	ROLLER ROD
169	P0550169	ROLLER
170	P0550170	STRAIGHT KNIFE, SET OF 3
171	P0550171	GIB BOLT
172	P0550172	GIB
173	P0550173	MACHINE ID LABEL (G0550)
173	P0551173	MACHINE ID LABEL (G0551)
174	PLABEL-12	READ MANUAL LABEL
175	PLABEL-15	EAR PROTECTION LABEL
176	PLABEL-37	RESPIRATOR/GLASSES LABEL
177	P0550177	UNPLUG LABEL
178	P0550178	BELT COVER LABEL
179	PLABEL-14	ELECTRICITY LABEL
180	P0550180	LEG
181	P0550181	LONG SIDE BRACE
182	P0550182	SHORT SIDE BRACE
183	P0550183	LONG TOP BRACE
184	P0550184	SHORT TOP BRACE
185	PB03	HEX BOLT 5/16-18 X 1
186	PCB02	CARRIAGE BOLT 5/16-18 X 1/2
187	PN02	HEX NUT 5/16-18
188	PLW04M	LOCK WASHER 8MM
190	PW01M	FLAT WASHER 8MM
191	P0550191	STAND TOP
192	PW01M	FLAT WASHER 8MM
193	PN03M	HEX NUT M8-1.25

Troubleshooting Guide

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Motor will not start.	1. Low voltage. 2. Open circuit in motor or loose connections.	1. Check power line for proper voltage. 2. Inspect all lead connections on motor for loose or open connections.
Motor will not start; fuses or circuit breakers blow.	1. Short circuit in line cord or plug. 2. Short circuit in motor or loose connections. 3. Incorrect fuses or circuit breakers in power line.	1. Inspect cord or plug for damaged insulation and shorted wires. 2. Inspect all connections on motor for loose or shorted terminals or worn insulation. 3. Install correct fuses or circuit breakers.
Motor overheats.	1. Motor overloaded. 2. Air circulation through the motor restricted.	1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded.	1. Inspect connections on motor for loose or shorted terminals or worn insulation. 2 Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Machine slows when operating.	1. Feed rate too high. 2. Depth of cut too great.	1. Feed workpiece slower. 2. Reduce depth of cut.
Loud, repetitious noise coming from machine	1. Pulley setscrews or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belt is defective	1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Tighten fan or shim cover. 3. Replace V-belt. **See Maintenance.**
Machine is loud when cutting. Overheats or bogs down in the cut.	1. Excessive depth of cut. 2. Knives are dull	1. Decrease depth of cut. 2. Sharpen knives.
Infeed roller marks are left on the workpiece.	1. Depth of cut too shallow.	1. Increase depth of cut.
Outfeed roller marks are left on right side of workpiece.	1. Too much spring tension on feed roller.	1. Refer to Feed Roller Pressure section for adjustment.
Cannot control snipe.	1. Long or heavy board sags as it enters and exits.	1. Lift up on unsupported end of board as it enters and exits cutterhead.
Chip buildup on outfeed roller.	1. Chips working their way back under the chip deflector.	1. Lay duct tape over the mounting bolts along the outside edge to seal any possible gaps.
Machine howls on startup.	1. Chip deflector too close to the cutterhead.	1. Move chip deflector back 1/8" to 1/4" from the cutterhead.
Table moves down while cutting.	1. Knives dull. 2. Cutterhead is not locked.	1. Replace knives. 2. Tighten cutterhead lock knobs.

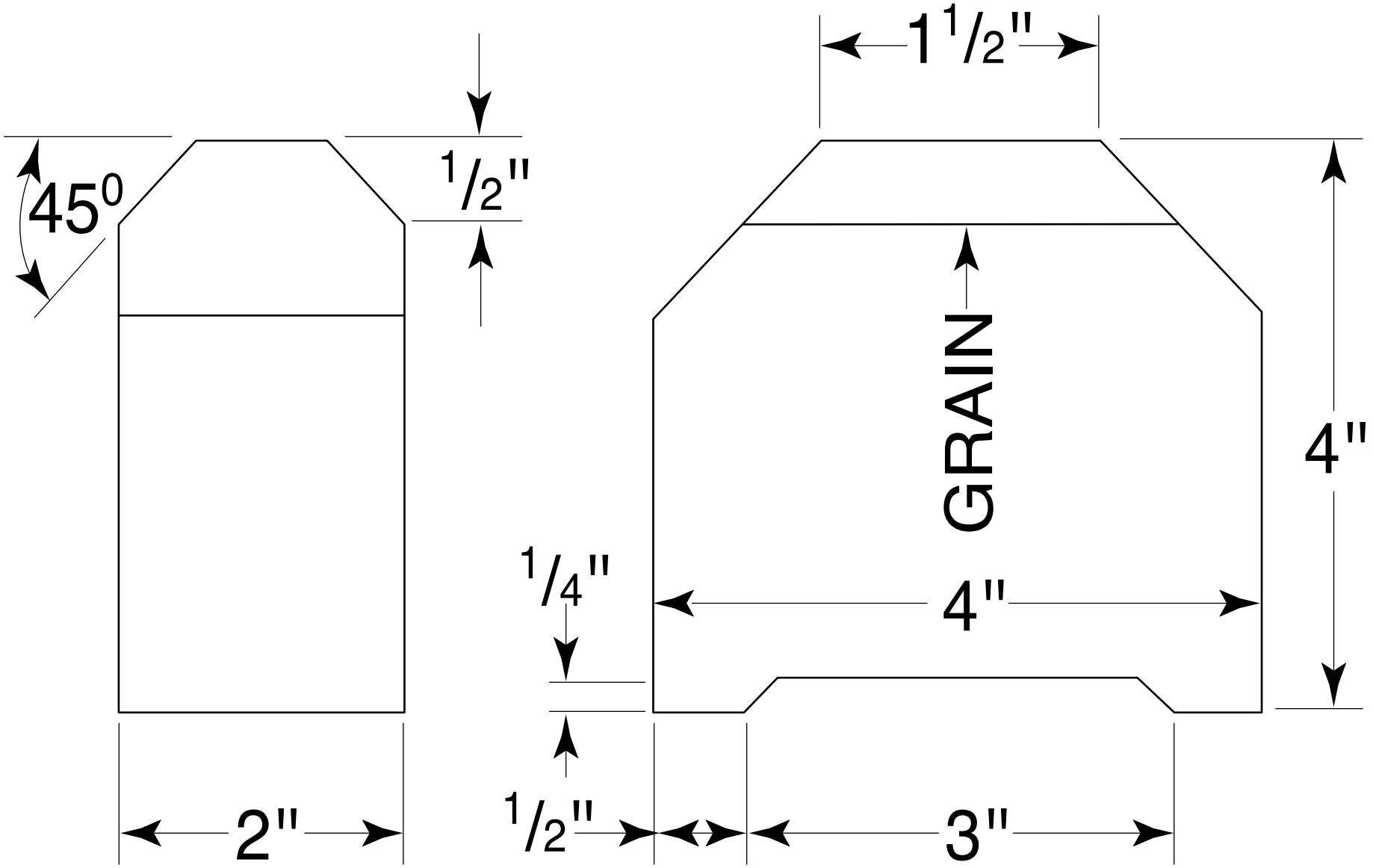
G0550/G0551 Wiring Diagram



⚠DANGER

Disconnect power from machine before performing any electrical service. Failure to do this will result in a shock hazard leading to injury.

Gauge Block Measurements



Warranty & Returns

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

WARRANTY CARD

Name _____

Street _____

City _____State_____Zip_____

Phone Number_____E-Mail_____FAX_____

MODEL #_____**Serial #** _____ Order #_____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

1. How did you learn about us?

___Advertisement
___Catalog
___World Wide Web
___Friend
___Card Deck

___Other_____

2. Which of the following magazines do you subscribe to.

___American Woodworker
___Cabinetmaker
___Family Handyman
___Fine Homebuilding
___Fine Woodworking
___Home Handyman
___Journal of Light Construction
___Old House Journal
___Popular Mechanics
___Popular Science
___Popular Woodworking
___Practical Homeowner
___Shop Notes
___Today's Homeowner
___WOOD
___Wooden Boat
___Woodshop News
___Woodsmith
___Woodwork
___Woodworker
___Woodworker's Journal
___Workbench

___Other_____

3. Which of the following woodworking/remodeling shows do you watch?

___Backyard America
___Home Time
___The American Woodworker
___The New Yankee Workshop
___This Old House
___Woodwright's Shop

___Other_____

4. What is your annual household income?

___$20,000-$29,999
___$30,000-$39,999
___$40,000-$49,999
___$50,000-$59,999
___$60,000-$69,999
___$70,000-$79,999
___$80,000-$89,999
___$90,000 +

5. What is your age group?

___20-29
___30-39
___40-49
___50-59
___60-69
___70 +

6. How long have you been a woodworker?

___0 - 2 Years
___2 - 8 Years
___8 - 20 Years
___20+ Years

7. How would you rank your woodworking skills?

___Simple
___Intermediate
___Advanced
___Master Craftsman

8. What stationary woodworking tools do you own? Check all that apply.

___Air Compressor
___Bandsaw
___Drill Press
___Drum Sander
___Dust Collector
___Horizontal Boring Machine
___Jointer
___Lathe
___Mortiser
___Panel Saw
___Planer
___Power Feeder
___Radial Arm Saw
___Shaper
___Spindle Sander
___jointer
___Vacuum Veneer Press
___Wide Belt Sander

___Other_____

9. How many of your woodworking machines are Grizzly? _____

10. Which benchtop tools do you own? Check all that apply.

___1" x 42" Belt Sander
___5" - 8" Drill Press
___8" jointer
___8" - 10" Bandsaw
___Disc/Belt Sander
___Mini Jointer
___6" - 8" Grinder
___Mini Lathe
___10" - 12" Thickness Planer
___Scroll Saw
___Spindle/Belt Sander

___Other_____

11. How many of the machines checked above are Grizzly? _____

12. Which portable/hand held power tools do you own? Check all that apply.

___Belt Sander
___Biscuit Joiner
___Circular Saw
___Detail Sander
___Drill/Driver
___Miter Saw
___Orbital Sander
___Palm Sander
___Portable Planer
___Saber Saw
___Reciprocating Saw
___Router

___Other_____

13. What machines/supplies would you like Grizzly Industrial to carry?

_____

_____

14. What new accessories would you like Grizzly Industrial to carry?

_____

_____

15. What other companies do you purchase your tools and supplies from?

_____

_____

16. Do you think your purchase represents good value?

___Yes ___No

17. Would you recommend Grizzly Industrial to a friend?

___Yes ___No

18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**

___Yes ___No

19. Comments:_____

_____

_____

_____

_____

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